JUKI®

2-NEEDLE, 2/3/4/5-THREAD OVERLOCK SEWING MACHINE
双针二／三／四／五线包缝机

MO-655

INSTRUCTION MANUAL
操作指南
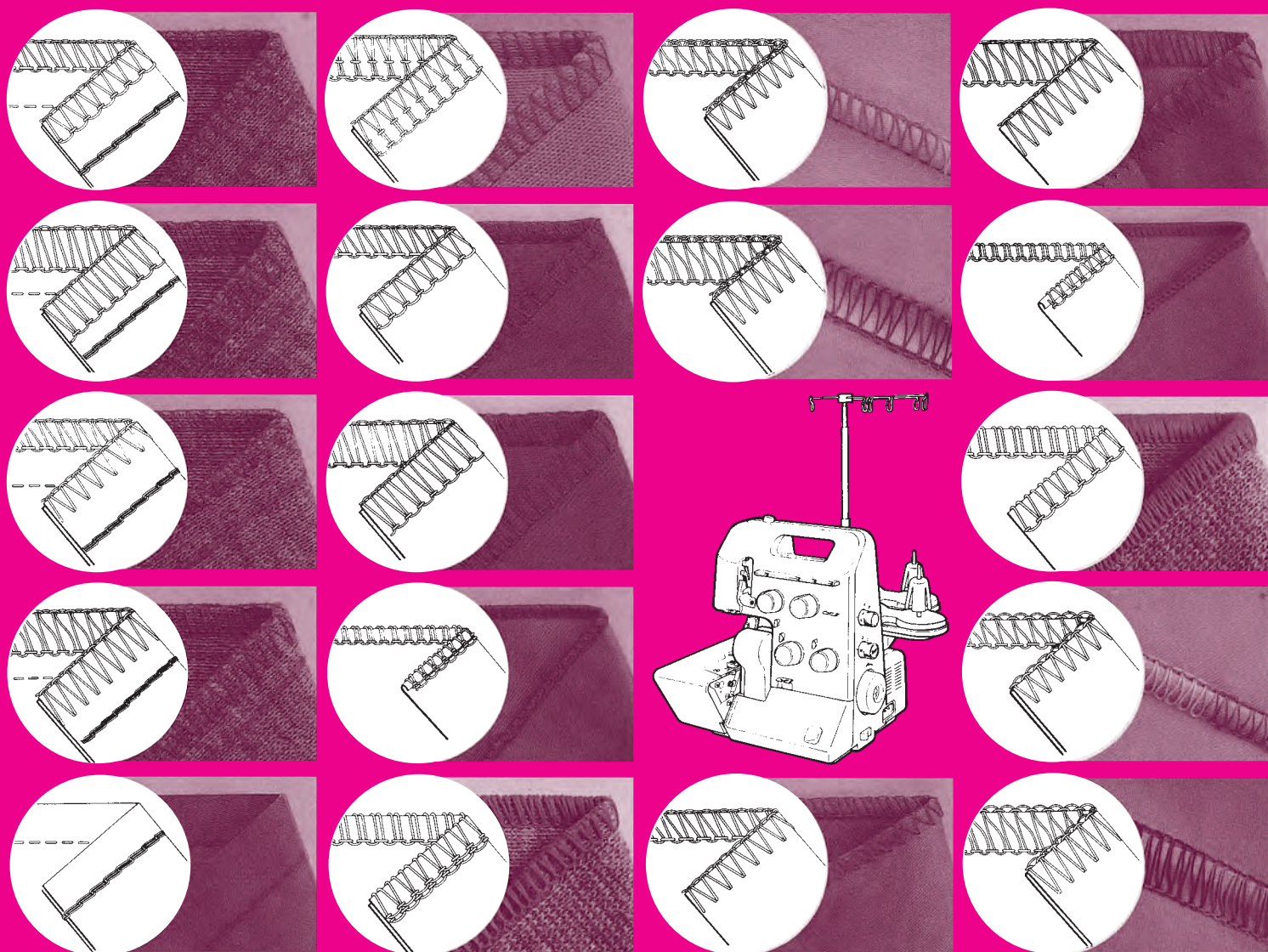
"IMPORTANT SAFETY INSTRUCTIONS"

When using an electrical appliance, basic safety precautions should always be followed, including the following:
Read all instructions before using this sewing machine.

"DANGER —— To reduce the risk of electric shock:"

1. An appliance should never be left unattended when plugged in.
2. Always unplug this appliance from the electric outlet immediately after using and before cleaning.
3. Always unplug before re-lamping. Replace bulb with same type rated 15W (120V), 10W (230/240V).

"WARNING —— To reduce the risk of burns, fire, electric shock, or injury to persons:"

1. Do not allow this appliance to be used as a toy. Close attention is necessary when this appliance is used by or near children.
2. Use this appliance only for its intended use as described in this manual. Use only attachments recommended by the manufacturer as contained in this manual.
3. Never operate this appliance if it has a damaged cord or plug, if it is not working properly, if it has been dropped or damaged, or dropped into water. Return the appliance to the nearest authorized dealer or service center for examination, repair, electrical or mechanical adjustment.
4. Never operate the appliance with any air openings blocked. Keep ventilation openings of the sewing machine and foot controller free from the accumulation of lint, dust, and loose cloth.
5. Keep fingers away from all moving parts. Special care is required around the sewing machine needle and knife.
6. Always use the proper throat plate. The wrong plate can cause the needle to break.
7. Do not use bent needles.
8. Do not pull or push fabric while stitching. It may deflect the needle causing it to break.
9. Switch the sewing machine off "0" when making any adjustments in the needle area, such as threading needle, changing needle, threading looper, or changing presser foot, and the like.
10. Always unplug the machine from the electrical outlet when removing covers, when covers are opened to raise the knife or thread the loopers, when lubricating, or when making any other user servicing adjustments mentioned in the instruction manual.
11. Never drop or insert any object into any opening.
12. Do not use outdoors.
13. Do not operate where aerosol (spray) products are being used or where oxygen is being administered.
14. To disconnect, turn all controls to the off "0" position, then remove plug from outlet.
15. Do not unplug by pulling on cord. To unplug, grasp the plug, not the cord.
16. Basically the machine should be disconnected from the electricity supply when not in use.

"SAVE THESE INSTRUCTIONS"

This overlock sewing machine is intended for household use only.

"重要的安全操作规则"

重点安全说明：
由于本机器有电器装置，所以在使用前必须时刻注意最基本的安全规则，阅读所有操作说明。

危险———谨防电击

1. 当接上电源时，机器必须有人照看。机器使用后以及清洁前，必须拔下电源插头。
2. 用后和清扫机器时，请拔去插头。
3. 换灯泡时，请拔去插头，更换灯泡规格为10W(220～240V)。

警告———谨访烧伤，失火，电击或伤害

1. 勿将该机器当作玩具，小孩靠近时须有大人看护。
2. 按照操作指南说明的用途使用，其附属装置仅限于指南中指定的。
3. 若出现线绳或插头损坏，工作失灵，机器被摔过或损坏或接触到水等问题时，请停止使用，并将其送到附近的指定经销商或售后服务中心进行检查，维修，电气或机械调整。
4. 任何通风孔受堵都需停止使用。保持缝纫机通风，并且保持脚踏控速器的清洁，防止棉线、灰尘和碎布的堆积。
5. 勿让手指接触转动的零件，尤其是缝纫机的各种针和刀。
6. 请正确使用合适的针板，错误使用会产生断针现象。
7. 不要使用弯曲的机针。
8. 在缝制时，请不要推或拉面料以免使针偏离而产生断针。
9. 调整任何针时，应停止缝纫机。例如：机针穿线，更换针，弯针穿线或更换压脚等。
10. 当移动罩板、打开罩板以抬高刀或弯针、添加润滑油和为用户进行售后服务调整机器时，请拔去插头。
11. 不要向入口处塞入任何东西。
12. 勿在户外使用。
13. 正使用喷雾产品或充满氧气的地方禁止使用机器。
14. 切断电源时，请将所有可控部位调至关闭状态，然后拔去插头。
15. 切断电源时，应直接拔下插头，请勿拉扯电缆。
16. 不使用时，应将缝纫机电源断开。

"妥善保存此操作指南"

本包缝机仅适合于家庭用。

Contents / 内容

Details of the machine
各部位的名称

1. Looper cover
2. Looper cover opening handle
3. Chip guard cover
4. Cloth plate
5. Throat plate
6. Presser foot
7. Lower looper thread tension dial
8. Upper looper thread tension dial
9. Right-hand needle thread tension dial
10. Left-hand needle thread tension dial
11. Thread take-up cover
12. Thread guide plate
13. Presser foot adjusting screw
14. Light bulb
15. Power/light switch
16. Handwheel (pulley)
17. Machine socket
18. Spool holders
19. Anti-vibration cone
20. Spool pin
21. Retractable support rod
22. Thread guide
23. Open thread guide
24. Presser foot lifter
25. Anti-vibration pad
26. Stitch length adjusting knob
27. Differential feed adjusting knob

1. 弯针罩板
2. 弯针罩板开关凹槽
3. 布屑挡板
4. 缝台
5. 针板
6. 压脚
7. 下弯针线张力调节旋钮
8. 上弯针线张力调节旋钮
9. 右机针线张力调节旋钮
10. 左机针线张力调节旋钮
11. 挑线杆护罩
12. 线导向板
13. 压脚调节旋钮
14. 灯泡
15. 电源／照明开关
16. 飞轮
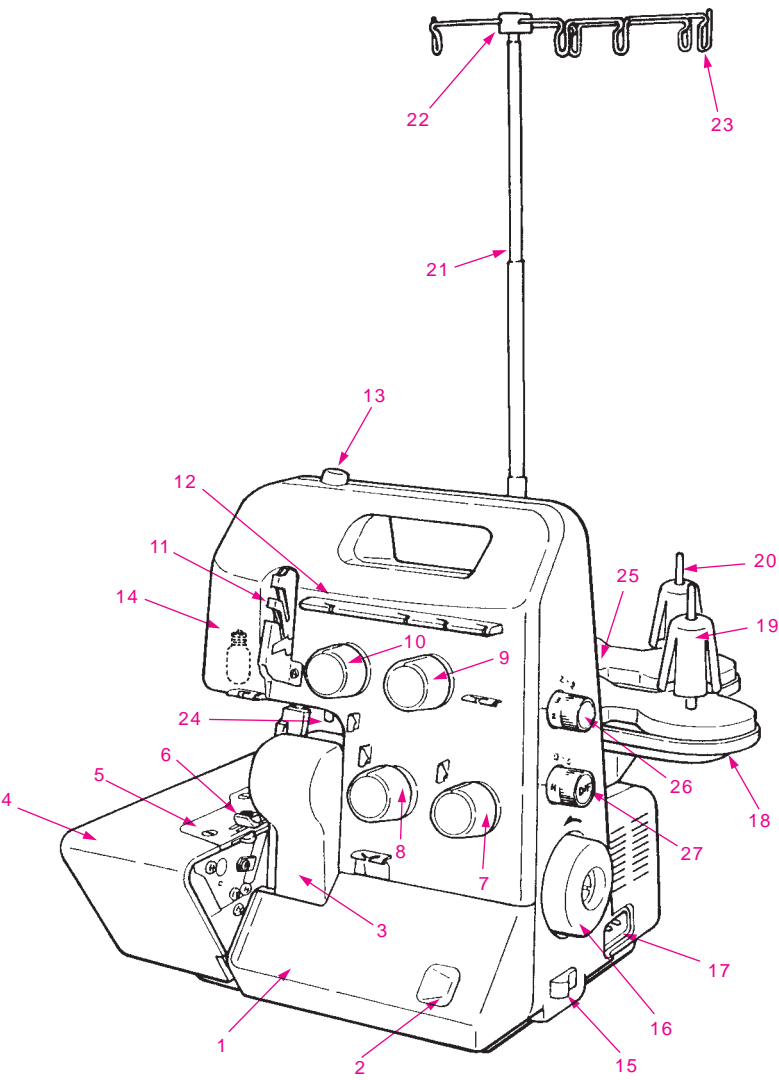17. 插座
18. 线架座
19. 防松垫
20. 插线钉
21. 线架棒
22. 线架帽
23. 挂线导向
24. 抬压脚扳手
25. 防震垫
26. 针距调节旋钮
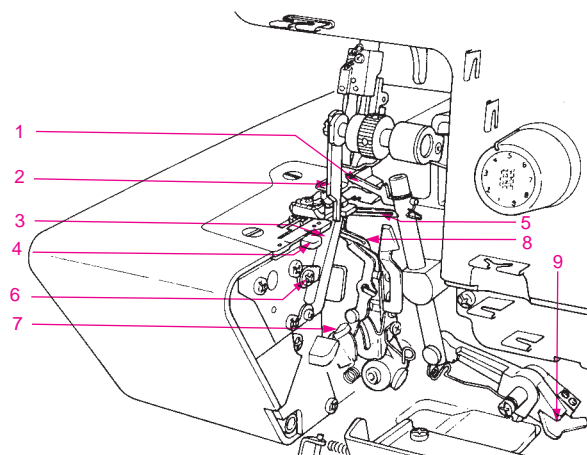27. 差动送料调节旋钮

Details of the machine
各部位名称

View with looper cover open
1. Upper looper
2. Upper knife
3. Lower knife
4. Overlock width selection knob
5. Lower looper
6. Lower knife setscrew
7. Lower looper threader
8. Chainstitch looper
9. Upper looper release

打开弯针罩板所见
1. 上弯针
2. 上刀
3. 下刀
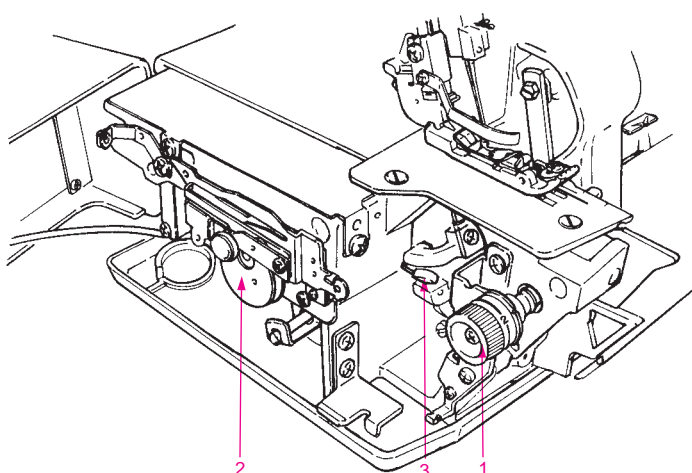4. 包缝宽度选择扳手
5. 下弯针
6. 下刀压板螺钉
7. 下弯针穿线扳手
8. 链缝弯针
9. 上弯针切换扳手

View with cloth plate open
1. Knife adjusting knob
2. Chainstitch looper thread take-up
3. Chainstitch looper threader

打开缝台所见
1. 下刀调节旋钮
2. 链缝弯针天秤
3. 链缝弯针穿线扳手

Accessories
1. Foot control
2. Lower knife blade
3. 2/3 thread converter
4. Nets
5. Spool caps
6. Tweezers
7. Cleaning brush
8. Needle threader
9. Needles in the needle box
10. Small screwdriver
11. Large screwdriver
12. Oiler
13. Accessory bag
14. Dust cover
15. Chainstitch seam guide plate

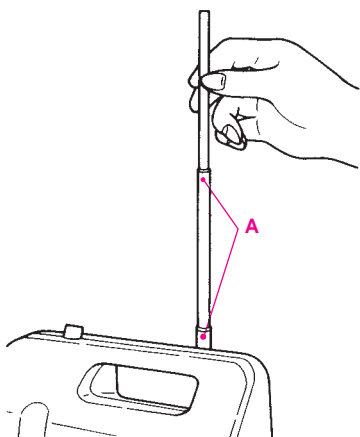**附件：**
1. 脚踏控速器
2. 下刀
3. 2/3线转换器
4. 线团网
5. 线团座
6. 镊子
7. 除尘刷
8. 机针穿线器
9. 机针盒
10. 小螺丝刀
11. 大螺丝刀
12. 油壶
13. 附件袋
14. 机头罩
15. 链缝导向台
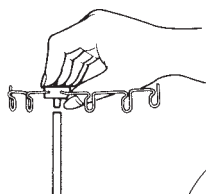
2
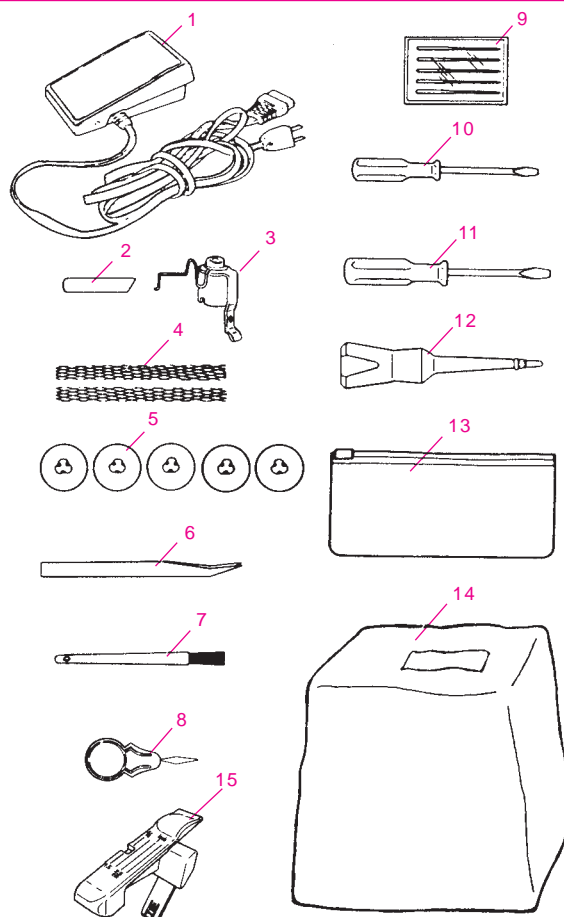
Assembling thread stand
组装线架

Raise the support rod fully

Turn the thread stand until it engages the positioning stopper (A) with a click.

抽出线架杆

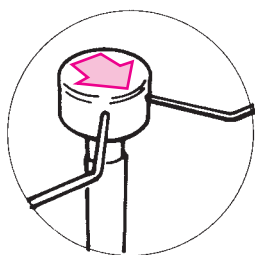转动线架棒直到听到〝咔哒〞时，即A处的两定位珠卡入孔中，表明线架棒中的定位珠已啮合。

Put the thread guide on the support rod.

Insert the thread guide into the tip of the support rod so that the arrow in the thread guide points toward you.
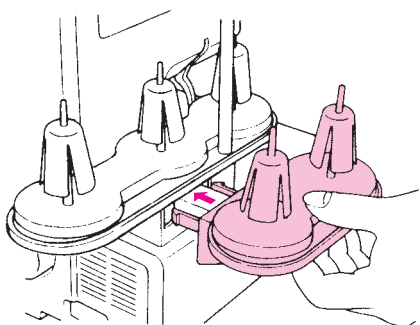
将线架帽插入线架棒顶部

注意使线架帽上的箭头朝向自己。

Attaching the spool holders

Attach the separately packed spool holder (equipped with two spool holders pins) to the fixed spool holder, by pushing until it snaps in place.
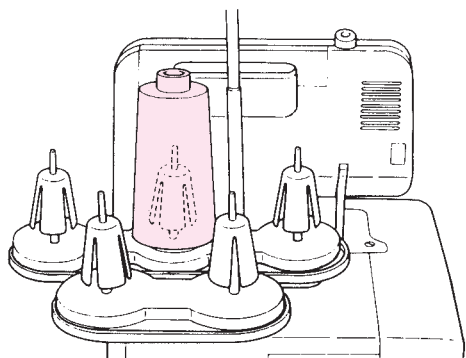
装入线架座

将辅助的线架座（随机配有一副）与已固定在机器上的线架座相连，注意要插到底。

Assembling the thread stand
组装线架

For overlock spools

包缝用线团

For large spools
For spools of large inside diameter, position the anti-vibration come upside down.
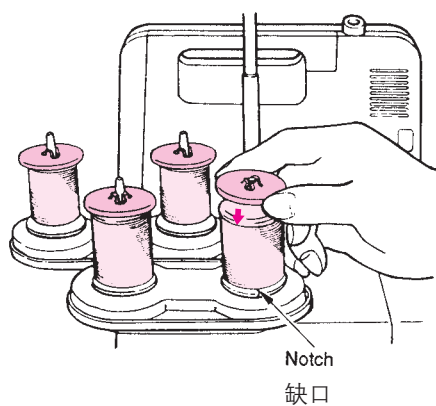
大号线团
对于大内径的线团，请将线团防松垫倒置插紧。
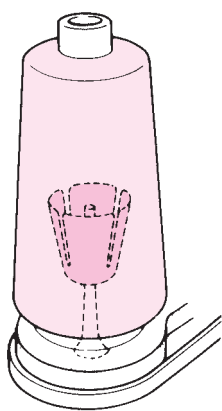
For home sewing spools
When using home sewing spools, remove the anti-vibration cones.
Place a spool on the spool holder with its notch downward and push the spool caps on with the rounded outside edge at the bottom.
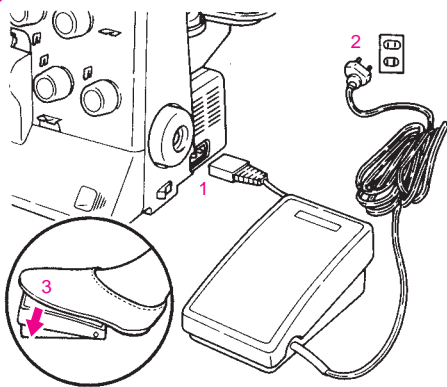
家用缝纫线团
使用家庭缝纫线团时，去掉线团防松垫。
将线团插入插线钉，注意线团座缺口朝下，然后按上、并使其凸出的面向上。

Notch
缺口

Preparing machine
运转前准备

Attaching the foot control

1. Plug foot control into machine socket.
2. Plug foot control into power supply socket.
3. Lay your foot on the foot control.
   Press firmly on the foot control to increase sewing speed.
   Press lighty on the foot control to decrease sewing speed.

脚踏控速器的连接

1.将脚踏控速器的插头插入机器上的插座。
2.将脚踏控速器的另一头插头插入电源插座。
3.用脚控制速度。用力踩速度提高，轻踩速度降低。
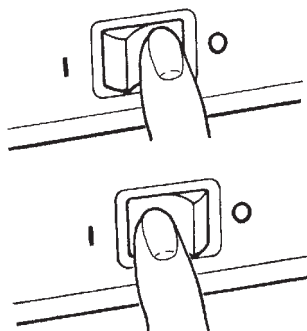
Power/light switch

The power/light switch is conveniently placed on the handwheel side of the machine in front of the socket.
O = Off
I = On with light

主电源／照明灯开关

主电源／照明灯开关位于飞轮下方。
O ＝ 关
I ＝ 打开照明灯

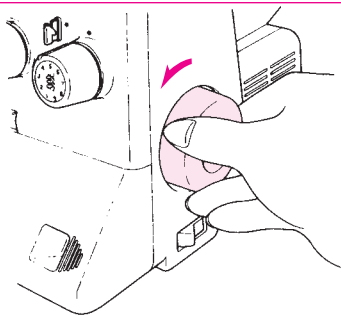### When you do not use the sewing machine:

1. Turn the power/light switch off. (Position A)
2. Pull the machine plug out from the power supply socket.
3. Never place anything on the foot control.

当您不使用本机时：

1.关闭电源／照明开关。
2.拔去电源插头。
3.勿在脚踏控速器上放置任何东西。

Operation and function
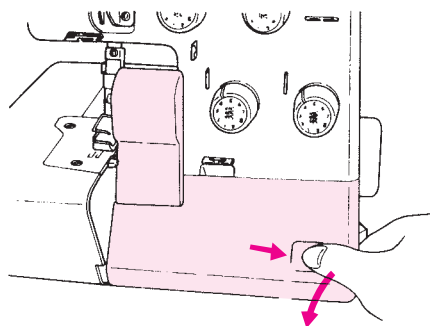## 操作及功能

Handwheel (Pulley)

The handwheel turns toward you.
* Upon completion of threading, at sewing start or sewing end, be sure to turn the handwheel toward you.

飞轮（皮带轮）

飞轮要正转。
* 穿线结束后，开始缝纫或结束缝纫时，必须正转飞轮。
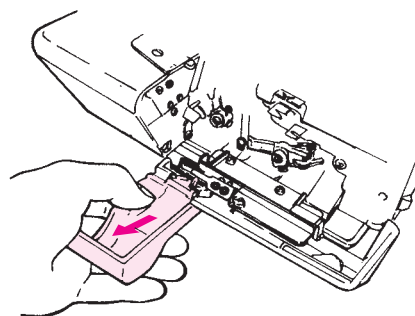
Opening and closing the looper cover

Opening: To open the looper cover, pull the looper cover opening handle to the right, and tilt the looper cover toward you.

Closing: To close the looper cover, push up the looper cover, press it lightly to the right. The looper cover closes automatically.

弯针罩板的开闭

打开：将弯针罩板向右拉，并朝自己方向打开。
关闭：将弯针罩板向上翻起，并轻轻向右一按，弯针罩板即自动关闭。

Removing and attaching the chip guard cover

Removing the chip guard cover:
    To remove the chip guard cover, open the looper cover and draw the chip guard cover toward you until it comes off.
Attaching the chip guard cover:
    To install the chip guard cover, open the looper cover and attach the chip guard cover in position wihle fitting its top end in the slit on the looper cover.

取下和安装布屑挡板

取下布屑挡板：
如需取出布屑挡板，请打开弯针罩板并向自己的方向拉出。
安装布屑挡板：
如需安装布屑挡板，请打开弯针罩板并安装布屑挡板，使其顶端插入弯针罩内槽口，至完全嵌合。
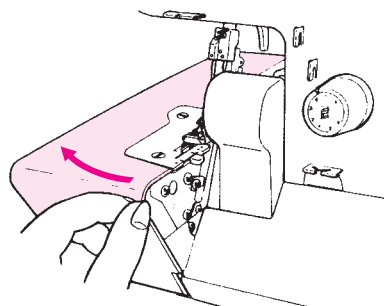
Opening and closing the cloth plate

Opening: Press the cloth plate toward the outside.
Closing: Push the cloth plate toward the sewing machine.

缝台的开闭

打开：向外推缝台。
关闭：将缝台向打开的相反方向推。

⚠ **Caution** For safety, the power is automatically cut off when you open the looper cover or the cloth plate or remove the chip guard cover.

⚠ **注意**：为了安全起见，当打开弯针罩板和缝台时，机器将自动切断电源。

Operation and function
## 操作及功能

Presser foot lifter (To raise the presser foot by the presser foot lifter)

A For regular sewing operation (sewing a medium-weight material), raise the presser foot to position (A) illustrated in the figure.

B When you sew a heavy-weight material, raise the presser foot to position (B) illustrated in the figure, to provide more space between presser foot and throat plate.
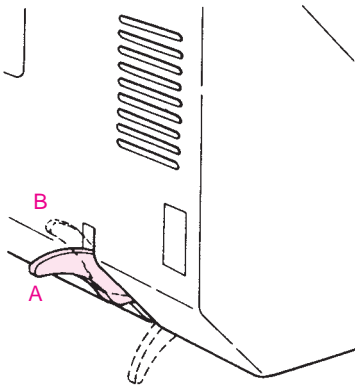
压脚扳手 （可抬起压脚）

A 通常缝纫时（即缝纫中等厚度的面料）将压脚扳手抬至A位置，放入面料。

B 在缝纫较厚面料时，按图示将压脚抬至B位置，以在压脚和针板间留出更多的间隙。

Changing the presser foot
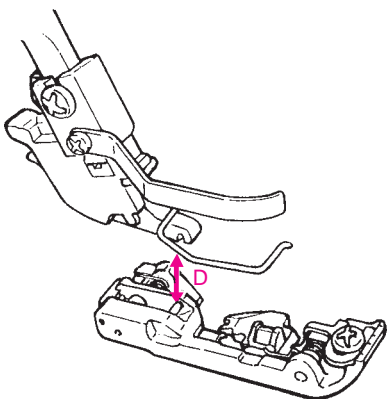
⚠ Be sure to turn the power switch OFF.

1. Raise the presser foot.
2. Turn the handwheel until the needles are fully raised.
3. To release the presser foot, raise the presser foot lifting lever to its highest position (B). Then you can release the presser foot easily.
4. Press point (C) illustrated in the figure, and the presser foot will be released.
5. To attach the presser foot , place it so that the presser foot pin comes exactly under the groove in the holder. Lower the presser foot lifting lever and the presser foot will engage automatically (D).
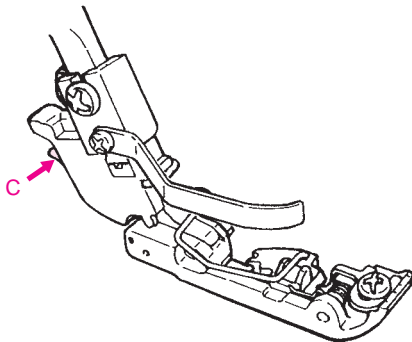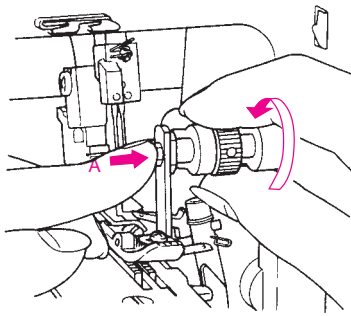
更换压脚

⚠ 必须切断电源。

1.抬起压脚。
2.转动飞轮，使机针转至最高点。
3.如须取下压脚，请将压脚扳手抬至最高位置（B），使压脚足更易于取下。
4.按下图示C点，便可取下压脚。
5.装上压脚，使压脚销正好卡在压脚架的凹槽内，放下压脚扳手，压脚便会自动到位（D）。

Operation and function
操作及功能

Releasing the upper knife
⚠ Be sure to turn the power switch OFF.
1. Turn the handwheel until the upper knife is fully raised. Open the looper cover.
2. Press the part indicated as (A) in the figure toward the right until it will go no further.
3. Keep pressing (A) and turn the knob on the right side in the direction of the arrow.
4. Turn the knob until the knife reaches position (B), and snaps into locked position.
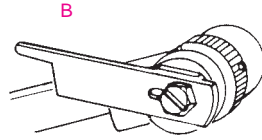
翻转上刀
⚠ 注意要切断电源。
1. 转动飞轮，使上刀处于最高位置，再打开弯针罩板。
2. 向右按下图中所示的A部分，直到完全按入。
3. 按着A点不放，按箭头所示转动右边的止动轮。
4. 转动止动轮到B点，并转到死点位置。
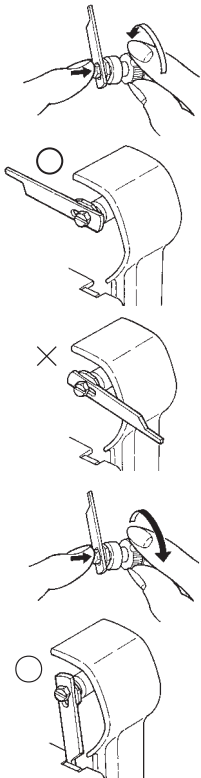
Caution, Raising and lowering the upper knife.
注意：抬起并放下上刀

⚠ **Caution** Make sure to set the upper knife at a prescribed position.
注意： 将上刀设定到规定的位置。

1 Raising the upper knife. Turn the knob clockwise until the knife reaches a prescribed position. Don't set the knife on the halfway position.
抬起上刀。顺时针转动止动轮直到上刀位于规定的位置。

2 Lowering the upper knife. Turn the knob counterclockwise until the knife reaches a prescribed position. Don't set the knife on the halfway position.
放下上刀。逆时针转动止动轮直到上刀位于规定的位置。
中途禁止使用上刀。

**Lower knife adjusting knob** (adjusting the lower knife position for cutting width)
⚠ Be sure to turn the power switch OFF.
Turn the lower knife adjusting knob by pressing part (C) in the figure.
● (E): If the edge of the sewing material curls, set the lower knife adjusting knob (D) to a lower number setting.
● (F): If the thread is loosely looping on the outer edge of the material, set the lower knife adjusting knob, to a larger number setting.

Accione hacia abajo la perilla de ajuste del cuchillo (ajustando la posición del cuchillo inferior)
Asegúrese de desconectar la alimentación posicionando en OFF el interruptor.
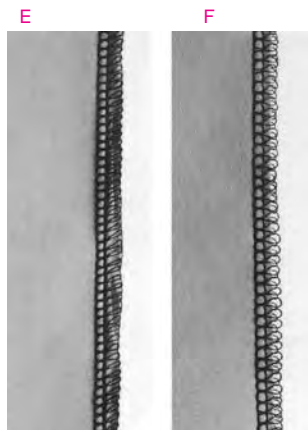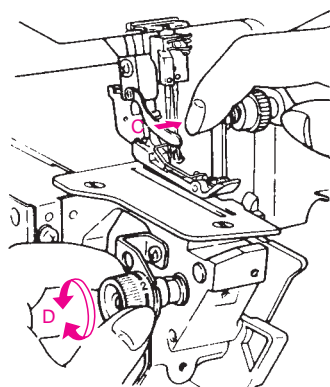
下刀调节旋钮（调节切刀宽度）
⚠ 注意要切断电源。
按下图中所示C点后再转动下刀调节旋钮。
● (E)：如果面料边卷起，将下刀调节旋钮（D）数值刻度调小。
● (F)：如果线在面料边外松散成圈，将下刀调节旋钮刻度调大。
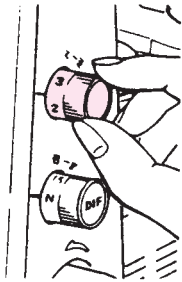
Operation and function
操作及功能

Stitch length adjusting knob (to adjust the stitch length)

Stitch length is adjustable within the range from 1 to 4.

To adjust the stitch length, turn the stitch length adjusting knob and move the knob upwards or downwards.

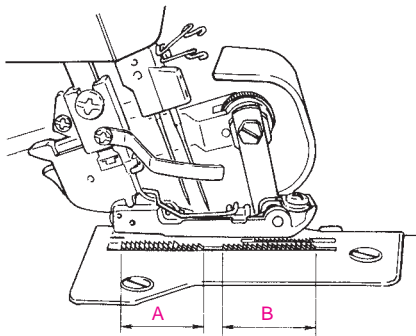● For normal overlocking stitches set the stitch length adjusting knob at 2 to 3.

针距调节旋钮（调节针距）

针距长度的可调范围1～4 mm。

通过转动针距调节旋钮来调节针距。

● 通常包缝设定长度值为2～3 mm。

Differential feed adjusting knob (To adjust the feeding for gathering or stretching)

To adjust feeding for gathering or stretching, turn the differential feed adjusting knob upward or downward.
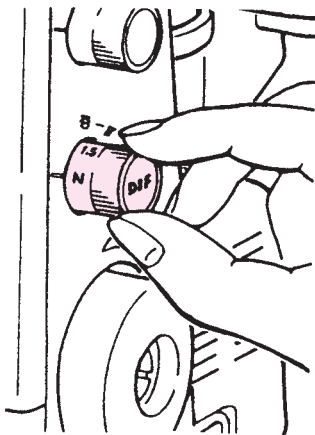
The differential feed prevents fluting or waving in seams in stretchy materials by differentiating the feed of the front feed dog (A) and rear feed dog (B).

For more application, information, see page 36.
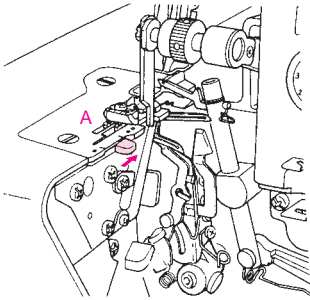
差动送料调节旋钮（根据收缩或拉伸的需要调节送布量）

向前或向后转动差动送料调节旋钮来调节送布量

转动差动送料调节旋钮，以调节前送布牙（A）和后送布牙（B）的送料速比，可避免弹性面料的缝口出现缺口或波浪状。

Operation and function
操作及功能

Overlocking width selection knob (For overlocking or roll hemming)

* Turn the handwheel until the needles are fully raised
A For overlocking
   Push the overlocking width selection knob should align with the rear red marking on the throat plate.
B For roll hemming
   1. Pull the overlocking width selection knob should align with the front red marking on the throat plate.
   2. Set the lower knife adjusting knob at "1 ~ 2".

包缝宽度选择扳手（用于包缝或卷边）

* 转动飞轮，使机针至最高点。
A 包缝时
   将包缝宽度选择扳手朝前推，使其与针板后面红色标记对齐。
B 卷边时
   1.将包缝宽度选择扳手朝后拉，使其与针板前面红色标记对齐。
   2．将下刀调节旋钮调至〝1～2〞。
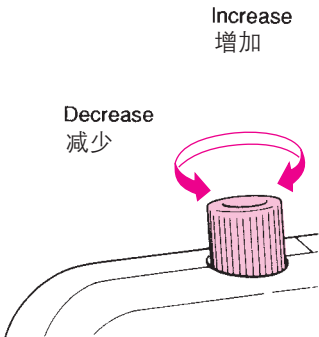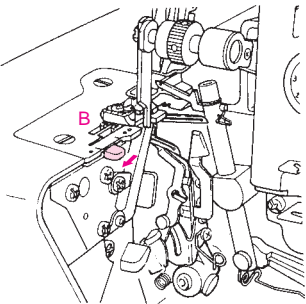
Increase
增加

Decrease
减少

Presser foot pressure adjusting screw

Pressure of the presser foot has been factory-adjusted properly.
Therefore you do not need to adjust it except when sewing a special material.

● To increase the pressure of the presser foot:　　　　For heavy-weight materials such as denim, tweed, or heavy linen.
● To decrease the pressure of the presser foot:　　　　For light-weight materials such as georgette, lace, or tricot.

(C): Standard position:　　　The lower part of control cap aligns with the upper face of cover.
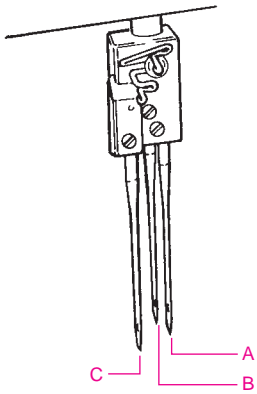
压脚压力调节旋钮

压脚压力调节旋钮已由厂方在出厂时调试适当。
因此，除缝纫特殊面料之外，无需再调节
● 增加压脚压力：用于厚质面料，如粗斜纹棉布、斜纹软呢或粗亚麻布。
● 减小压脚压力：用于轻质面料，如乔其纱、蕾丝或针织织物。
   （C）标准位置：使压脚调节帽下部与机壳的表面对齐。

C
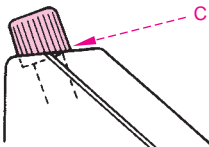
Operation and function
操作及功能

Changing the needles

⚠ Be sure to turn the power switch OFF.
● Using the needle inserter (D) on the cleaning brush will help replace the needle easily.
1. Turn the handwheel until the needles are fully raised.
2. Before changing the needles, lower or remove the presser foot.
3. Using a small screwdriver, loosen the needle setscrew and remove the needle.
4. Insert the needle with the flat side away from you into the needle clamp, making sure it is inserted as far up as possible. Tighten the needle clamp setscrews securely.

Needles used:		Types of needles	Size
A	Right-hand needle	Household type 130/705H	No. 75/11 or 90/14
B	Left-hand needle		
C	Chainstitch needle		

* Needle with No. 75/11 is intended for light-weight materials and general fabric.
Needle with No. 90/14 is intended for heavy-weight materials.

Note: To insert the needle into the needle clamp, loosen the needle clamp screw until flush with the clamp and insret the needle as far as possible into the clamp.
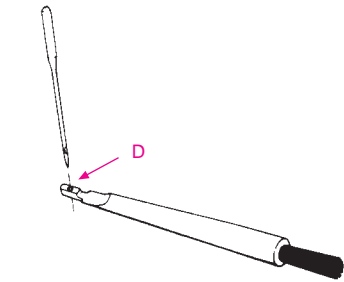
Flat side of a needle
机针平面

更换机针

⚠ 注意要切断电源
● 使用除尘刷柄部的机针插入器（D）将很容易的换下机针。
1.转动飞轮直到机针上升至最高点。
2.换机针前，取下或放低压脚。
3.用小螺栓刀松掉支针螺钉取下被换机针。
4.将右针柄平面向后，机针充分插入针夹，然后拧紧支针螺钉。

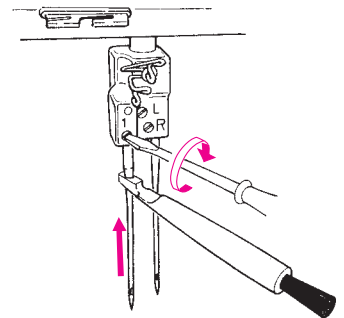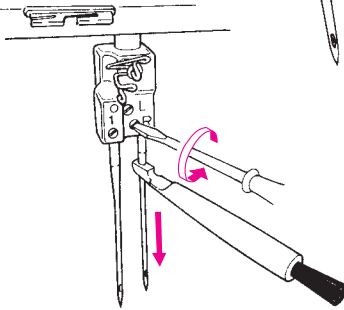| 所用机针		机针型号	规格
A	右机针	家用型 130/705H	No. 75/11 或 90/14
B	左机针		
C	链缝机针		

* No. 75/11 机针适用于轻质面料和乔其纱面料。
　No. 90/14 机针适用于厚质面料。

注意：将机针插入针夹时，拧开机针支针螺钉，然后将机针充分插入针夹里拧紧支针螺钉。

Stitch Chart

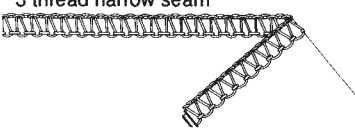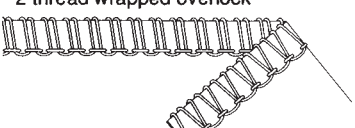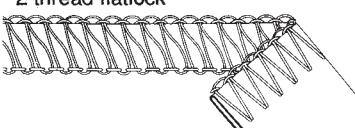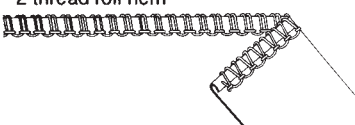| Stitch	Stitch width	Tension settings	Basic settings
5 thread overlock (chainstitch and narrow 3 thread overlock)	3 – 5 mm, right needle Chainstitch needle 10 mm	Right needle green 3 – 5 Upper looper blue 3 – 5 Lower looper red 3 – 5 Chainstitch needle purple 3 – 4 Chainstitch looper purple	Stitch length: 2, 5 Cutting width: 2 Differential: N
5 thread overlock (chainstitch and wide 3 thread overlock)	5 – 7 mm, left needle Chainstitch needle 10 mm	Left needle brown 6 – 7 Upper looper blue 3 – 5 Lower looper red 3 – 5 Chainstitch needle purple 3 – 4 Chainstitch looper purple –	Stitch length: 2, 5 Cutting width: 2 Differential: N
2 thread chainstitch	—	Chainstitch needle purple 3 – 4 Chainstitch looper purple –	Stitch length 2, 5 Knife: Raised, chainstitch seam guide plate used Differential: N – 2 (knits), N – 0,7 (wovens)
4 thread overlock, with integrated safety seam	5 – 7 mm, right and left needles	Left needle yellow 3 – 5 Right needle green 3 – 5 Upper looper blue 3 – 5 Lower looper red 3 – 5	Stitch length: 2, 5 Cutting width: 2 Differential: N – 2 (knits), N – 0,7 (wovens)
3 thread overlock	3 – 5 mm, right needle 5 – 7 mm, left needle	Left needle yellow 3 – 5 Right needle green 3 – 5 Upper looper blue 3 – 5 Lower looper red 3 – 5	Stitch length: 2, 5 Cutting width: 2 Differential: N – 1,5 (knits), N – 0,7 (wovens)
3 thread flatlock	3 – 5 mm, right needle 5 – 7 mm, left needle	Left needle yellow 1 – 2 Right needle green 1 – 2 Upper looper blue 3 – 5 Lower looper red 7 – 9	Stitch length: min. 2, 5 Cutting width: 2 Differential: N
3 thread roll hem	2 mm, right needle	Right needle green 4 – 6 Upper looper blue 3 – 5 Lower looper red 5 – 7	Stitch length: 1 – 1.8 Cutting width: 1 – 1.5 Differential: N – 0.7 Stitch lever: roll hem
3 thread narrow seam	2 mm, right needle	Right needle green 4 – 6 Upper looper blue 5 – 7 Lower looper red 3 – 5	Stitch length: 1 – 1.8 Cutting width: 1 – 1.5 Differential: N – 0.7 Stitch lever: roll hem
2 thread wrapped overlock	3 – 5 mm, right needle 5 – 7 mm, left needle	Left needle yellow 3 – 5 Right needle green 3 – 5 Lower looper red 2 – 4	Stitch length: 2.5 Cutting width: 2 Differential: N – 1,5 (knits), N – 0,7 (wovens)
2 thread flatlock	3 – 5 mm, right needle 5 – 7 mm, left needle	Left needle yellow 1 – 2 Right needle green 1 – 2 Lower looper red 4 – 6	Stitch length: min. 2, 5 Cutting width: 2 Differential: N
2 thread roll hem	1,5 mm, right needle	Right needle green 3 – 5 Lower looper red 2 – 4	Stitch length: 1 – 1.8 Cutting width: 1 – 1.5 Differential: N – 0.7 Stitch lever: roll hem

针迹对照表

针迹	针迹宽度	线的张力	基本设置
5线包缝(链缝+右机针3线包缝)	3—5 mm 右机针 链缝机针10 mm	右机针绿色3—5 上弯针蓝色3—5 下弯针红色3—5 链缝机针紫色3—4 链缝弯针紫色	针距：2.5 切刀宽度：2 差动：N
5线包缝(链缝+左机针3线包缝)	5—7 mm 左机针 链缝机针10 mm	左机针褐色6—7 上弯针蓝色3—5 下弯针红色3—5 链缝机针紫色3—4 链缝弯针紫色	针距：2.5 切刀宽度：2 差动：N
2线链缝	—————	链缝机针紫色3—4 链缝弯针紫色	针距：2.5 刀：抬起，使用链缝导向台 差动：N—2（针织织物）， N—0.7（平织织物）
4线完整标准包缝	5—7 mm，左右机针	左机针黄色3—5 右机针绿色3—5 上弯针蓝色3—5 下弯针红色3—5	针距：2.5 切刀宽度：2 差动：N—2（针织织物）， N—0.7（平织织物）
3线包缝	3—5 mm，右机针 或 5—7 mm，左机针	左机针黄色3—5或 右机针绿色3—5 上弯针蓝色3—5 下弯针红色3—5	针距：2.5 切刀宽度：2 差动：N—2（针织织物）， N—0.7（平织织物）
3线展开缝	3—5 mm，右机针 或 5—7 mm，左机针	左机针黄色1—2或 右机针绿色1—2 上弯针蓝色3—5 下弯针红色7—9	针距：2.5 切刀宽度：2 差动：N
3线卷边缝	2 mm，右机针	右机针绿色4—6 上弯针蓝色3—5 下弯针红色5—7	针距：1—1.8 切刀宽度：1—1.5 差动：N—0.7 包缝宽度选择扳手：卷边
3线窄边缝	2 mm，右机针	右机针绿色4—6 上弯针蓝色5—7 下弯针红色3—5	针距：1—1.8 切刀宽度：1—1.5 差动：N—0.7 包缝宽度选择扳手：卷边
2线卷缝	3—5 mm，右机针 或 5—7 mm，左机针	左机针黄色3—5或 右机针绿色3—5 下弯针红色2—4	针距：2.5 切刀宽度：2 差动：N—1.5（针织织物）， N—0.7（平织织物） 2/3线转换器
2线展开缝	3—5 mm，右机针 或 5—7 mm，左机针	左机针黄色1—2或 右机针绿色1—2 下弯针红色4—6	针距：最小2.5 切刀宽度：2 差动：N 2/3线转换器
2线窄卷缝	1.5mm，右机针线	右机针绿色3—5 下弯针红色2—4	针距：1—1.8 切刀宽度：1—1.5 差动：N—0.7 包缝宽度选择扳手：卷边 2/3线转换器

Threading / 穿线

Thread the machine carefully and in the correct sequence.
This is important for making beautiful seams.

Preparation

⚠️ Be sure to turn the power switch OFF.

1. Retractable support rod with thread guide must be fully raised.
2. Open the looper cover and cloth plate.
3. Turn the handwheel toward you until the needles are fully raised.
4. Release the upper knife.

Thread the machine carefully and in the correct sequence.
Invaluable threading aids simplify threading:

* colored threading illustration
* color coded thread path on the machine.
* threading accessories.

按正确顺序仔细对机器穿线，以缝纫出漂亮的针迹。

准备工作

⚠️ 请切断电源开关。

1. 将线架帽拉至最高点。
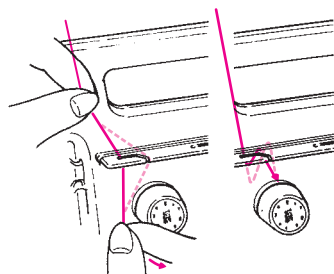2. 打开弯针罩板和缝台。
3. 正转飞轮，直至机针上升到最高点。
4. 解除上刀。

按正确顺序仔细穿线。
有效的穿线辅助手段可以使穿线更简便：

*彩色穿线图。
*机器上的彩色穿线通道。
*穿线附属品。

Thread guide plate

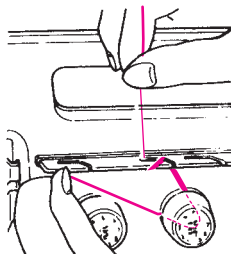Slide thread into the two slits to form an S-loop.
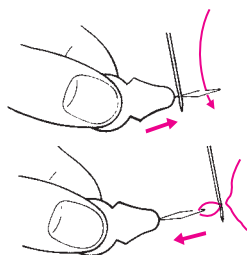
线导向板

将线滑进导向板槽，呈S型状态。

Threading the tension dials
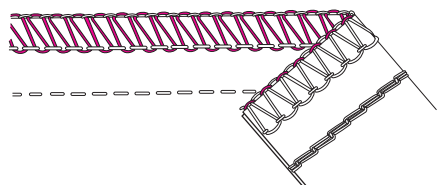
线张力刻度盘

Needle threader

Insert the needle threader through the back of the needle eye or the looper eye then thread the needle threader. Pull the needle threader back until it pulls through the eyelet.

机针穿线器

从机针针孔或弯针针孔后面插入机针穿线器，然后线穿进穿线器，向后拉出机针穿线器，将线引出针孔。

1. Upper looper thread (Blue)

Place the spool on the spool pin right under blue marking on the retractable support rod thread guide.

(1, 2) Bring thread up from the rear of the retractable support rod thread guide with blue marking, to the front of it.

(3, 4) Pass the thread through the thread guide plate. Looping as shown.
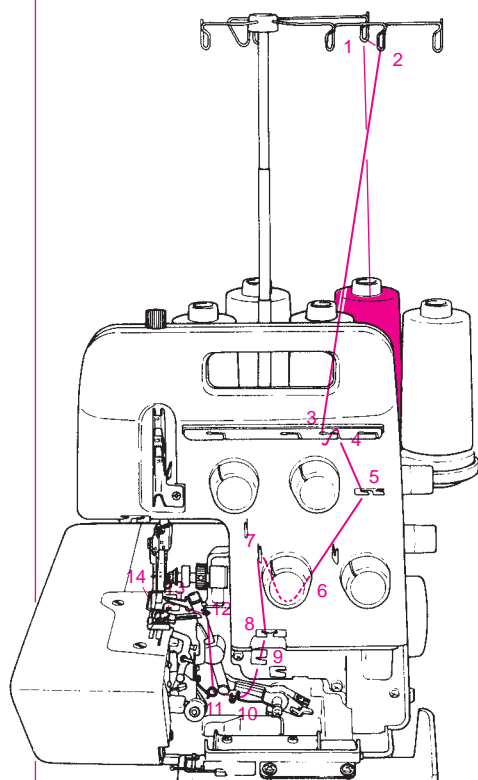
(5) Snap the thread into the thread guide.

(6) Lay the thread between the thread tension dial discs.

(7, 8, 9, 10, 11, 12) Thread the thread guides

(13) Turn the handwheel until the upper looper is fully raised.
Thread upper looper eye.

(14) Pull about 10 cm of the thread out.
Place the thread under the presser foot, and pull the thread from behind the presser foot.

1. 上弯针线（蓝色）

将线团插入带有蓝色色标的挂线导向下面的插线钉上。
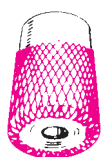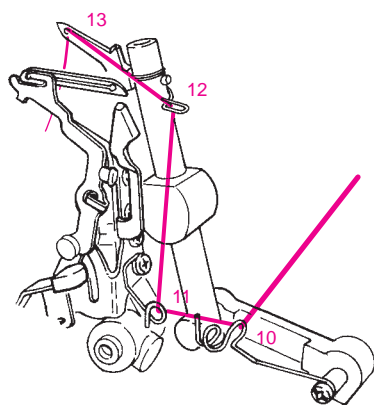
（1，2）将线挂在有蓝色色标的挂线导向上。

（3，4）将线通过线导向板。如图所示。

（5）将线通过线导向。

（6）将线嵌入上弯针线张力调节旋钮的夹线片中。

（7，8，9，10，11，12）将线依次通过各线导向。

（13）转动飞轮将上弯针转至最高点，线穿进上弯针针孔。

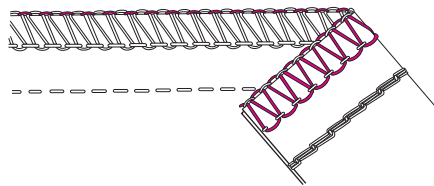（14）将线拉出大约10 cm。
将线从压脚下面通过，从压脚后面拉出线端。

Use a net for a hard twisted thread.

When a thread coils around the thread guide due to its hard twist, cover the spools of upper looper and lower looper with nets.

防止打圈的线团网

当线团的线滑落或打圈，可用线团网罩住上弯针和下弯针线团。

2. Lower looper thread (Red)

Place the spool on the spool pin right under red marking on the retractable support rod thread guide.

(1)   Bring thread up from the rear of the retractable support rod thread guide.
(2, 3) Pass the thread through the thread guide plate. Snapping into place.
(4)   Snap the thread in to the thread guide.
(5)   Thread the thread tension dial.
(6, 7, 8, 9)   Thread the thread guides.
(10)   Raise the needles fully and press the lever of the threading device down.
(11, 12) Thread the guide and then the slit on the device.
         Holding the thread loosely with the left hand, turn the hand wheel until upper and lower loopers just cross.
         The threading device will automatically return to the normal position.
(13)   Thread the lower looper eye and place thread under the presser foot.
    *   If rethreading the lower looper thread, cut the needle threads at the needle. And rethread needle threads.
         Thread the lower looper and then the needles.

2．下弯针线（红色）

将线团插入带有红色色标的挂线导向下面的插线钉上。
（1）将线挂在红色色标的挂线导向上。
（2，3）将线通过导线板。
（4）将线通过线导向。
（5）将线嵌入下弯针线张力调节旋钮的夹线片中。
（6，7，8，9）将线依次通过线导向。
（10）将机针转至最高点，按下下弯针穿线扳手。
（11，12）将线穿入。
         左手轻拿线头，正转飞轮直到上下弯针互相交叉，
         穿线装置将自动回复到正常位置。
（13）将线穿进下弯针，将线放在压脚下方。
    * 如需重新给下弯针穿线时，剪断左右机针线，给下弯针穿线后，再重新给机针穿线。

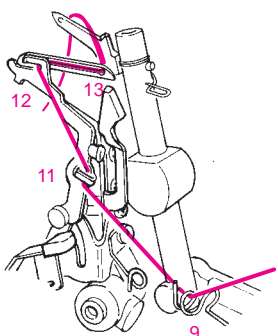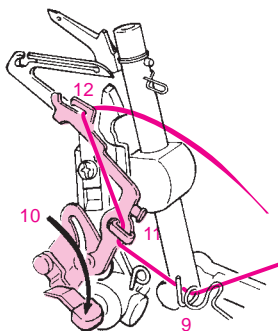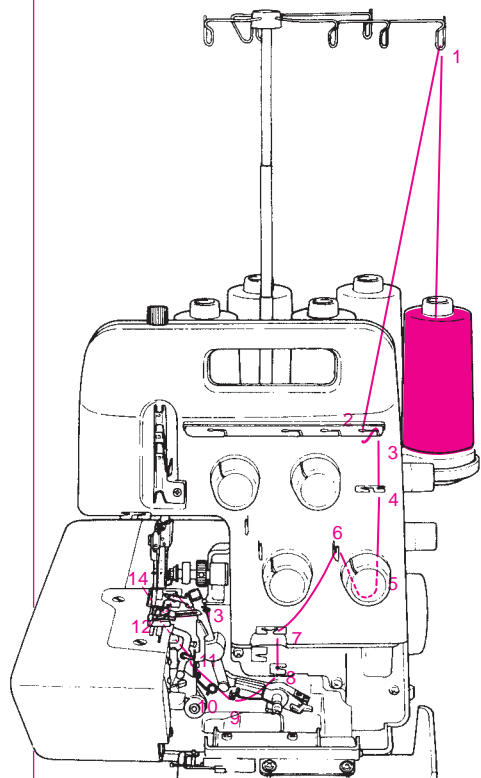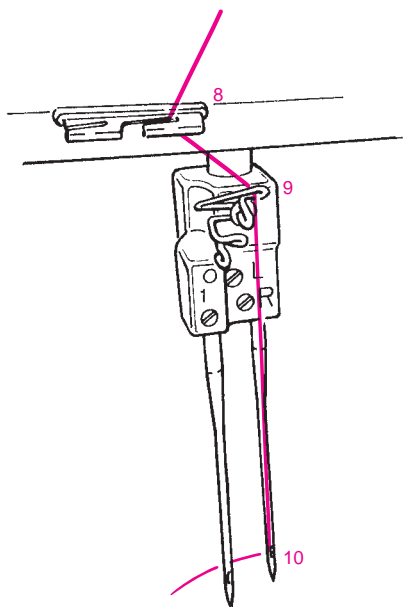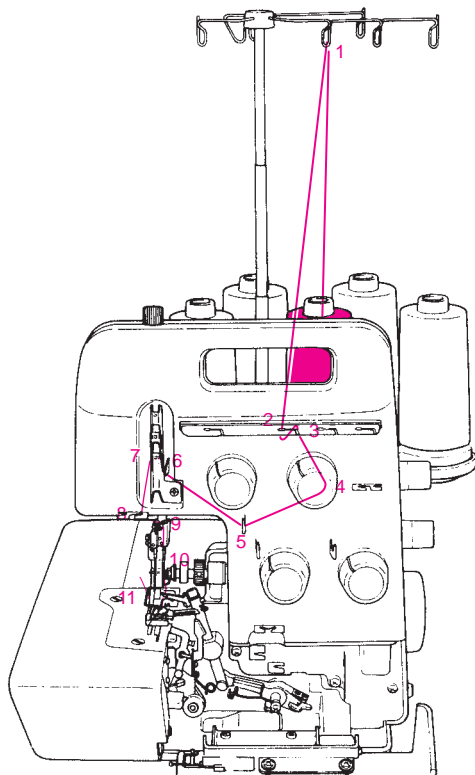穿线：5线包缝（链缝&3线包缝）
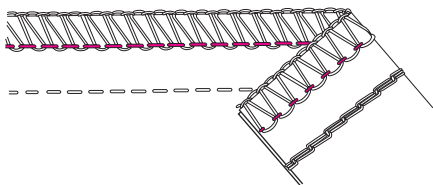
3. Right-hand needle thread (Green)

Place the spool on the spool pin right under the green marking on the retractable support rod thread guide.

(1)   Bring thread up from the rear of the retractable support rod thread guide with the green marking.
(2, 3) Pass the thread through the thread guide plate. Looping as shown.
(4)   Snap thread the thread tension dial.
(5, 6) Thread the thread guide.
(7)   Lay the thread in the under notch on the thread take-up cover.
(8)   Thread the thread guide.
(9)   Thread the thread guide on the needle clamp.
(10)   Turn the handwheel toward you until the needles are fully raised. Thread the right-hand needle.
(11)   Bring the thread through under the presser foot and pull about 10 cm of the thread out behind the presser foot.
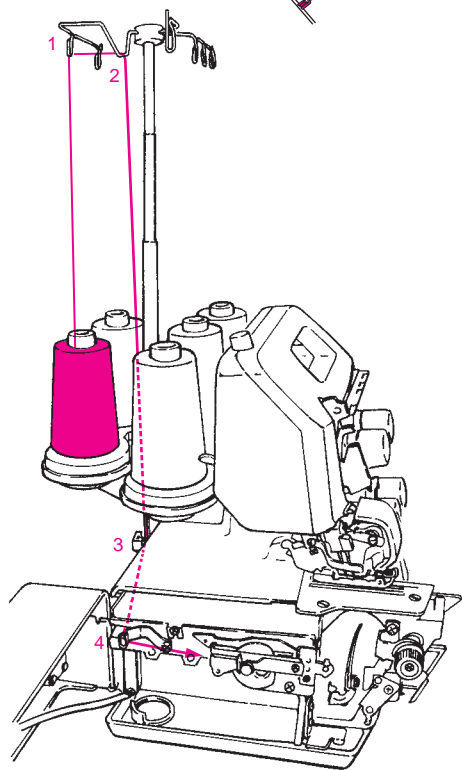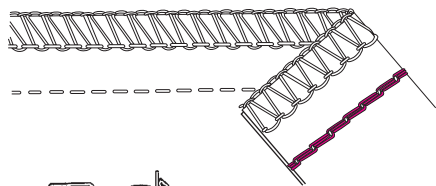
3.右机针线（绿色）

将线团插入带有绿色色标的挂线导向下面的插线钉上。
（1）将线挂在带有绿色色标的挂线导向上。
（2，3）将线通过线导向。如图所示打圈
（4）将线嵌入右机针线张力调节旋钮的夹线片中。
（5，6）将线通过线导向。
（7）将线穿过挑线杆护罩上的下方的过线槽（绿色）。
（8）将线通过线导向。
（9）将线通过针夹上的穿线钩。
（10）正转飞轮直到机针位于最高点。把线穿过针机孔。
（11）将线通过压脚下面，并在压脚后面拉出大约10 cm。

4. Chainstitch looper thread (Purple)

Place the spool on the spool pin right under the purple marking on the retractable support rod thread guide.

(1, 2) Bring the thread up from the spool and take it from back to front through the purple guides.

(3, 4) Thread guides on back of machine and inside the cloth plate.

(5, 6) Thread the tension.

(7) Place the thread horizontally in the guide.

(8) Thread the guide.

(9,10) Push the chainstitch looper auto-threader up towards the chainstitch looper and press them down together.

(11) Thread the auto-threader.

(12) Thread the looper eye from front to back and cut thread back to about 8 cm (3").

(13) Press the looper to the right and it will return to its normal position.

Note: If the chainstitch looper thread has to be rethreaded, cut the chainstitch needle thread at the eye and remove. Thread the looper first and then the needle.

4.链缝弯针线（紫色）

将线团插入带有紫色色标的挂线导向下面的插线钉上。

（1，2）将线从线团上拉出，从后向前通过紫色导向。

（3，4）通过机器后部的导向以及缝台内的导向。

（5，6）将线张力调节器穿线。

（7）将线水平绕入导向板上。

（8）线通过导向。

（9，10）把链缝弯针自动穿线扳手向上推起，并将链缝弯针往下倒。

（11）将线通过自动穿线器。

（12）从前向后将线穿过弯针孔，在大约8 cm （3″）处将线剪断。

（13）将弯针向右边推，它将恢复到缝纫位置。

注意：如果需要重新给链缝弯针线，在针孔上方剪断机针线并除去链缝机针线。然后先给弯针穿线，再给机针穿线。
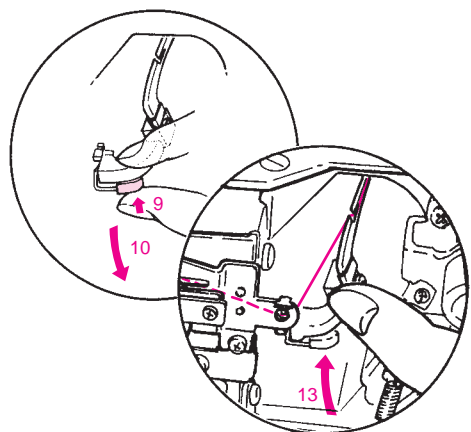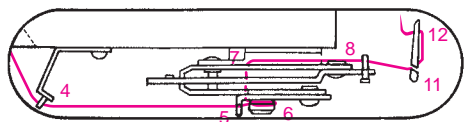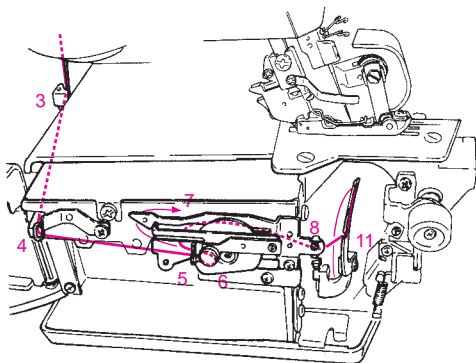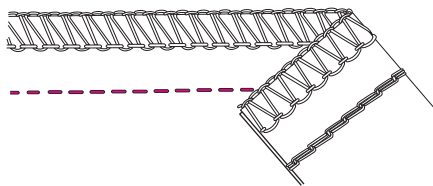
5. Chainstitch needle thread (purple)

Place the spool on the spool pin right under the puple marking on retractable support rod thread guide.

(1)   Bring the thread up from the spool to the thread guide and take it through the purple thread guide.

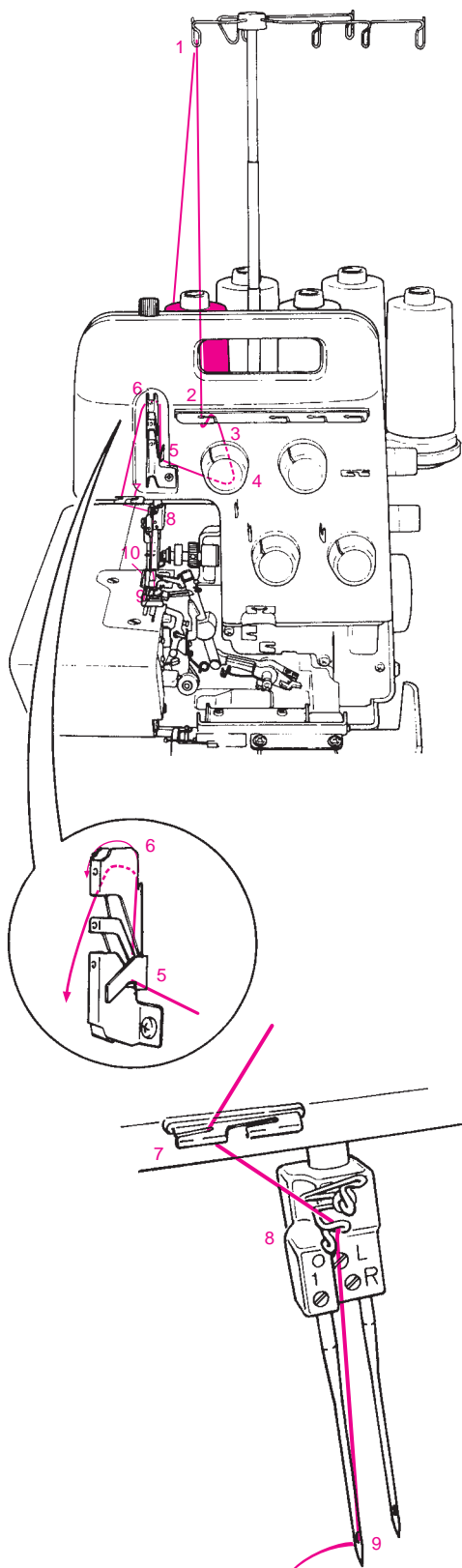(2, 3) Thread the thread guide.

(4)   Thread the thread tension dial.

(5)   Thread the thread guide.

(6)   Lay the thread in the up side notch on the thread take-up cover.

(7, 8, 9) Thread the thread guides.

(10)   Thread the chainstitch needle. Pull about 10 cm of the thread out from the needle eye.

When threading is completed, lower the upper knife and close the looper cover and cloth plate. Switch the machine on.

5．链缝机针线（紫色）

将线团插入带有紫色色标的挂线导向下面的插线钉上。

（1）将线从线团上拉出，挂在带有紫色色标的挂线导向上。

（2，3）将线通过导向。如图示打圈。

（4）将线嵌入左机针线张力调节旋钮的夹线片中。

（5）将线通过线导向。

（6）将线穿过挑线杆护罩上的上方的过线槽（紫色）。

（7，8，9）将线通过线导向。

（10）将线穿过链缝机针孔。并在机针孔处拉出大约10 cm。

穿线完毕后，放下上刀，关闭弯针罩板和缝台。 打开电源开关。

Left-hand needle (brown)

If chainstitch is sewn with a wide 3 thread overlock, use the left-hand needle and follow the brown markings. Place the spool on the spool pin under the brown markings on the thread guide.

(1) Bring the thread up from the spool and take it from back to front through the brown guide.
(2, 3) Pass the thread through the thread guide bar.
(4) Thread the thread tension dial.
(5, 6) Thread the thread guides.
(7) Thread the center notch of the take-up cover.
(8) Thread the guide.
(9) Thread the guide on the needle clamp.
(10) Thread the left-hand needle from front to back and lay the thread to the left under the presser foot.

- Chainstitch needle thread tension: 2.5 – 4.5 (A)
- Left-hand needle thread tension: 6 – 7 (B)
- Upper and lower looper thread tension: 3 – 5

When threading is complete
After threading, lower the foot and upper knife (if raised).
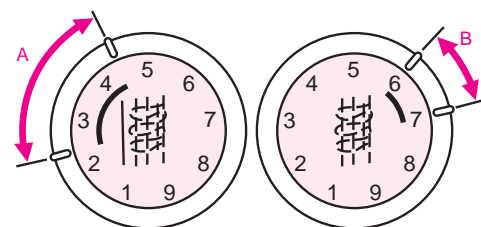Close the looper and cloth plate covers.
Switch the machine on.

左机针线（褐色）

如果用宽3线包缝链缝，请使用左机针线并沿褐色标志操作。将线团放在有褐色色标的挂线导向下面的插线钉上。

(1) 将线从线团上拉出，从后向前通过褐色线导向。
(2，3) 将线通过线导向。如图所示打圈。
(4) 将线嵌入右机针线张力调节旋钮的夹线片中。
(5，6) 将线通过线导向。
(7) 将线穿过挑线杆护罩上的上方的过线槽（紫色）。
(8) 将线通过线导向。
(9) 将线通过针夹上的穿线钩。
(10) 从前向后把线穿过左机针孔。将线放在压脚的左边。

* 链行缝机针线张力：2.5-4.5(A)
* 左机针线张力：6-7（B）
* 上下弯针线张力：3-5

穿线完毕
穿线完毕后，放下压脚和上刀（如果抬起）。
关闭弯针罩板。
打开机器电源。

2-thread chainstitch
2线链缝

2-thread chainstitch (Purple)

(1) Raise the upper knife.
(2) Remove the right and left-hand needles.
(3) Thread the chainstitch looper and needle.
(4) Open the looper cover and turn the handwheel towards you until the upper looper is in its lowest position (A).
(5) Push the upper looper release back to disengage the looper (B).
(6) Remove the knife guard (C) and attach the chainstitch seam guide plate (D).
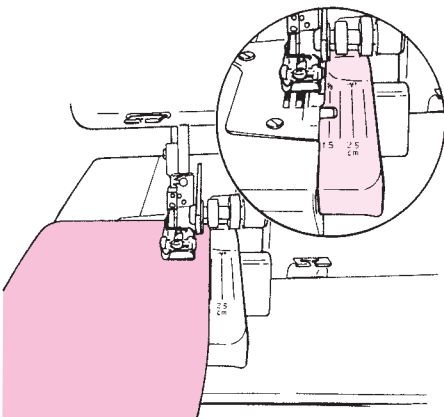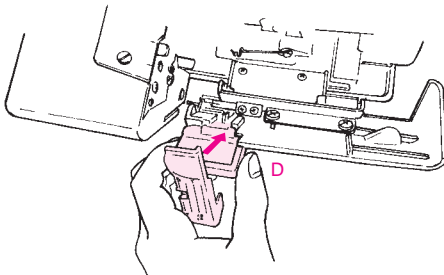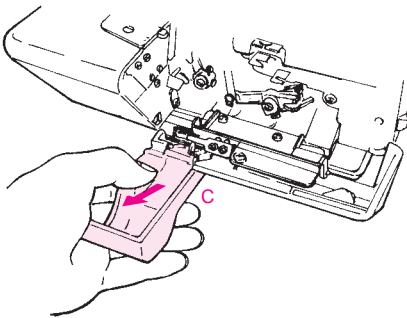(7) Close the looper cover.

Important : When you have finished chainstitch sewing, remove the seam guide plate and replace the knife guard, lock the upper looper, lower the knife and close the looper cover.
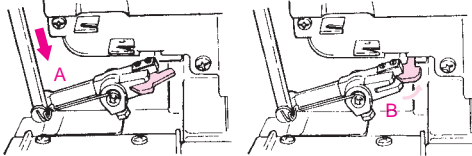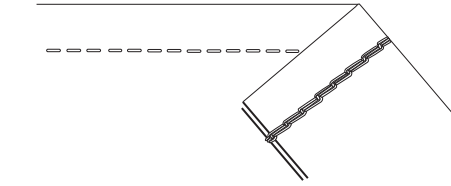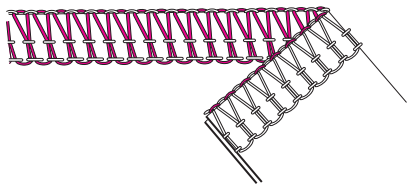
2线链缝（紫色）

（1）抬起上刀。
（2）取下左右机针。
（3）给链缝机针和弯针穿线。
（4）打开弯针罩板并转动飞轮直到上弯针处于其最低点（A）。
（5）向后推上弯针切换扳手，使其与弯针分离（B）。
（6）取下布屑挡板（C），并安装上链缝导向台（D）。
（7）关上弯针罩板。

注意：如果链缝缝纫完毕，取下链缝导向台并更换布屑挡板，锁住上弯针并关上弯针罩板。
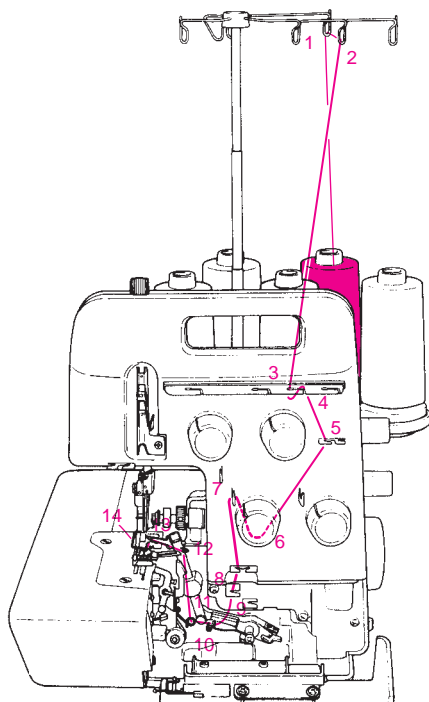
Threading: 4 thread overlock
穿线：4线包缝

1. Upper looper thread (Blue)

Place the spool on the spool pin right under blue marking on the retractable support rod thread guide.

(1, 2) Bring thread up from the rear of the retractable support rod thread guide with blue marking to the front of it.

(3, 4) Pass the thread through the thread guide plate. Looping as shown.

(5) Bring the thread on to the thread guide.

(6) Snap the thread into the thread tension dial discs.

(7, 8, 9, 10, 11, 12) Thread the thread guides

(13) Turn the handwheel until the upper looper is fully raised. Thread upper looper eye.

(14) Pull about 10 cm of the thread out. Place the thread under the presser foot, and pull the thread from behind the presser foot.

1.上弯针线（蓝色）

将线团插入带有蓝色色标的挂线导向下面的插线钉上。

（1，2）将线挂在有蓝色色标的挂线导向上。

（3，4）将线通过线导向板。如图所示。

（5）将线通过线导向。

（6）将线嵌入上弯针线张力调节旋钮的夹线片中。

（7，8，9，10，11，12）将线依次通过线导向。

（13）转动飞轮直到上弯针处于最高点。
　　　线穿进上弯针针孔。

（14）将线拉出大约10 cm。
　　　将线从压脚下面通过，并从后面拉出线端。

Threading: 4 thread overlock
穿线：4线包缝

2. Lower looper thread (Red)

Place the spool on the spool pin right under red marking on the retractable support rod thread guide.
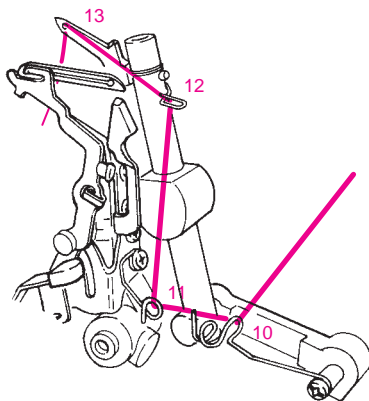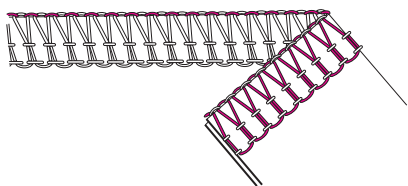
(1) Bring thread up from the rear of the retractable support rod thread guide.
(2, 3) Pass the thread through the thread guide plate. Looping as shown.
(4) Bring the thread on to the thread guide.
(5) Thread the thread tension dial.
(6, 7, 8, 9) Thread the thread guides.
(10) Raise the needles fully and press the lever of the threading device down.
(11, 12) Thread the guide and then the slit on the device.
Holding the thread loosely with the left hand, turn the hand wheel until upper and lower loopers just cross.
The threading device will automatically return to the normal position.
(13) Thread the lower looper eye and place thread under the presser foot.
* If rethreading the lower looper, cut the both needle threads off at the needles, and rethread the needles.
Thread the lower looper and then the needles.

2．下弯针线（红色）

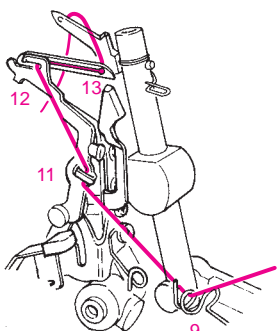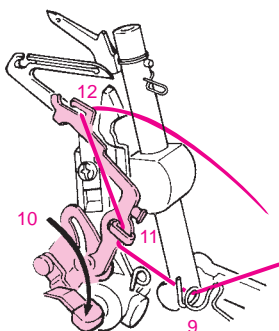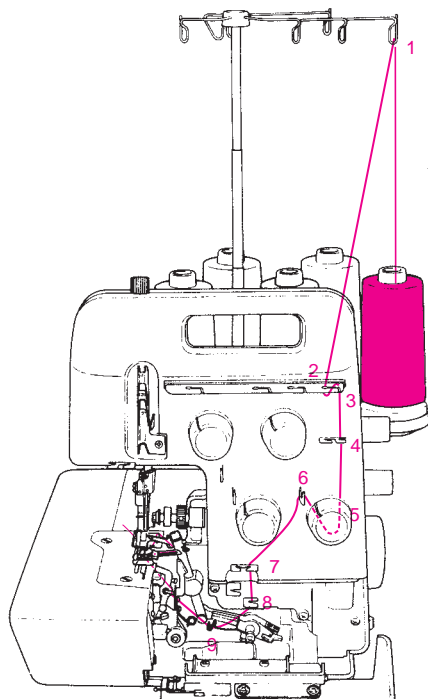将线团插入带有红色色标的挂线导向下面的插线钉上。

（1）将线从线团上拉出，从后向前通过线导向。
（2，3）将线通过线导向板。如图示打圈。
（4）将线通过线导向。
（5）将线嵌入下弯针线张力调节旋钮的夹线片中。
（6，7，8，9）将线依次通过各线导向。
（10）将机针位于最高点。
（11，12）将线穿入。
左手轻拿线头，转动飞轮直到上下弯针互相交叉。
穿线装置将自动回复到正常位置。
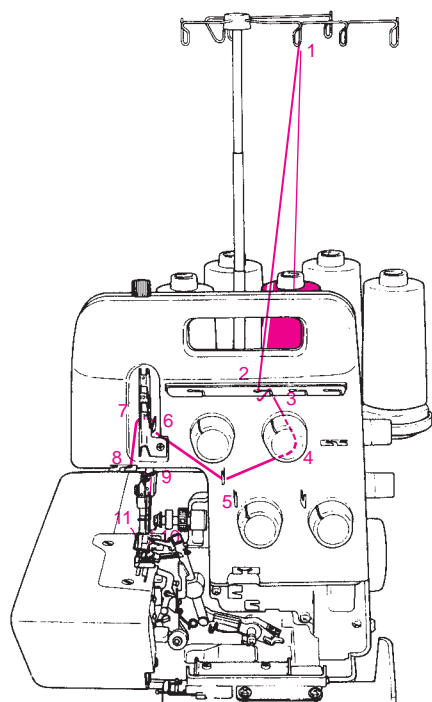（13）将线穿过下弯针孔，并将线放在压脚下方。
·如需重新给下弯针穿线时，剪断左右机针线。
先给下弯针穿线，再重新给机针穿线。

3. Right-hand needle thread (Green)

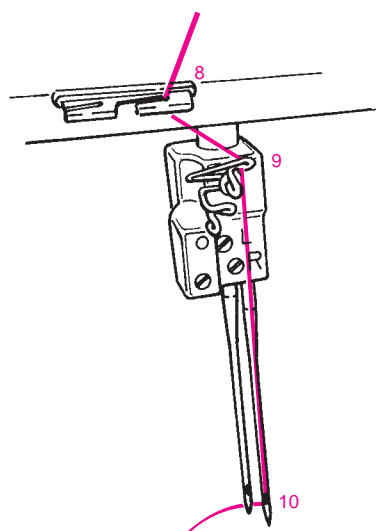Place the spool on the spool pin right under the green marking on the retractable support rod thread guide.

(1)   Bring thread up from the rear of the retractable support rod thread guide with the green marking.
(2, 3) Pass the thread through the thread guide plate. Looping as shown.
(4)   Thread the thread tension dial.
(5, 6) Thread the thread guide.
(7)   Lay the thread in the under notch on the thread take-up cover.
(8)   Thread the thread guide.
(9)   Thread the thread guide on the needle clamp.
(10)   Turn the handwheel toward you until the needles are fully raised. Thread the right-hand needle.
(11)   Bring the thread under the presser foot and pull about 10 cm of the thread out behind the presser foot.

3.右机针线（绿色）
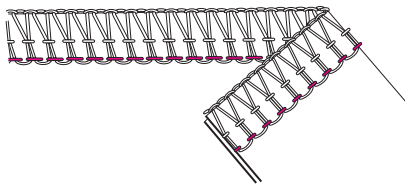
将线团放在有绿色色标的挂线导向下面的插线钉上。

(1)   将线从线团上拉出，挂在带有绿色色标的挂线导向上。
(2，3) 将线通过线导向。如图所示打圈。
(4)   将线嵌入右机针线张力调节旋钮的夹线片中。
(5，6) 将线通过线导向。
(7)   将线穿过挑线杆护罩上的下方的过线槽（绿色）。
(8)   将线通过线导向。
(9)   将线通过机针夹上的穿线钩。
(10)   正转飞轮使机针升至最高点。把线穿过右针针孔。
(11)   将线通过压脚下面，并从压脚后面拉出大约10 cm。

Threading: 4 thread overlock
穿线：4线包缝

4. Left-hand thread needle (Yellow)

Place the spool on the spool pin right under the yellow marking on retractable support rod thread guide.

(1)   Bring the thread up from the spool to the thread guide and take it through the yellow thread guide.

(2, 3) Thread the thread guide. Looping as shown.

(4)   Thread the thread tension dial.

(5)   Thread the thread guide.

(6)   Lay the thread in the center notch on the thread take-up cover.

(7, 8) Thread the thread guides.

(9)   Thread the left-hand needle. Pull about 10 cm of the thread out from the needle eye.
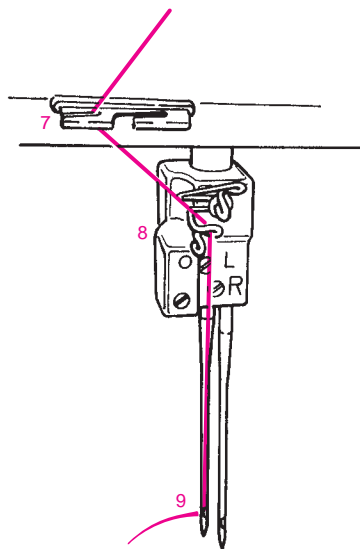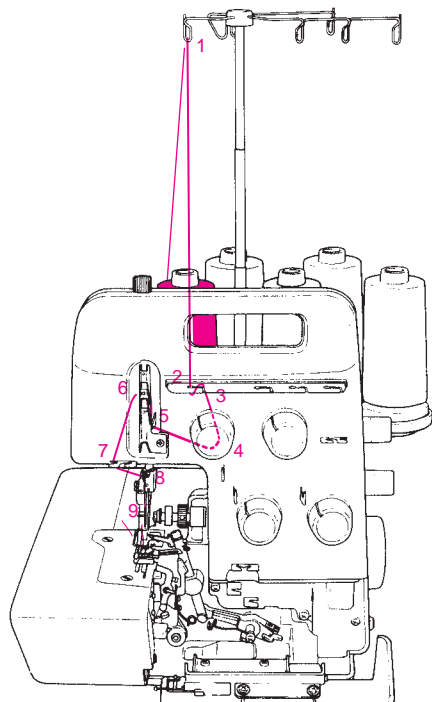
When threading is completed, lower the upper knife and close the looper cover and cloth plate.
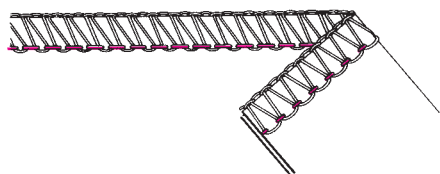
4．左机针线 （黄色）

将线团放在有黄色色标的挂线导向下面的插线钉上。

（1）   将线从线团上拉出，挂在带有黄色色标的挂线导向上。

（2，3）将线通过线导向。如图示打圈。

（4）   将线嵌入左机针线张力调节旋钮的夹线片中。

（5）   将线通过线导向。

（6）   将线穿过挑线杆护罩上的上方的过线槽（黄色）。

（7，8）将线通过线导向。

（9）   穿左机针线，并从机针孔拉出大约10 cm。

穿线完毕后，放下上刀并关闭弯针罩板和缝台。
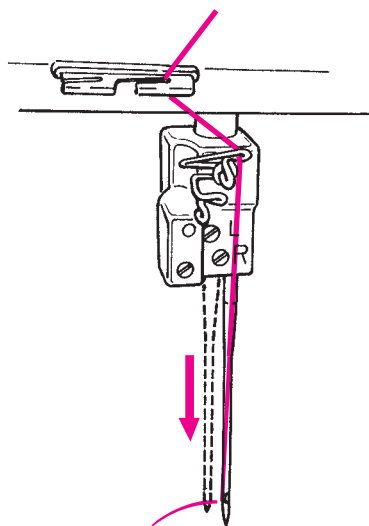
3-thread overlocking

3线包缝

4 mm wide 3-thread overlocking (Right-hand needle) (Blue, red, and green)

* Remove the left-hand needle.

Thread in the following order.
(1)　　Upper looper thread (Blue)
(2)　　Lower looper thread (Red)
(3)　　Right-hand needle thread (Green)

* If the machine is already threaded with the left-hand needle cut off and remove the thread.

4 mm宽3线包缝（右机针线）（蓝色、红色、绿色）

* 取下左机针。
按如下顺序穿线。
（1）上弯针线（蓝色）
（2）下弯针线（红色）
（3）右机针线（绿色）
* 如果机器左机针线已经穿线完毕，剪下并除去多余的线。

6 mm wide 3-thread overlocking (Left-hand needle) (Blue, red, and yellow)

* Remove the right-hand needle.

Thread in the following order.
(1) Upper looper thread (Blue)
(2) Lower looper thread (Red)
(3) Left-hand needle thread (Yellow)

* If the machine is already threaded with right-hand needle thread, cut off and remove the thread.
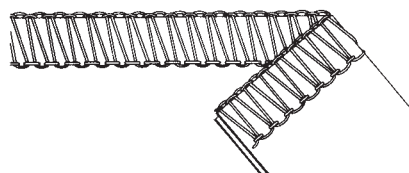
6 mm宽3线包缝（左机针线）（蓝色、红色、黄色）

* 取下右机针。
按如下顺序穿线。
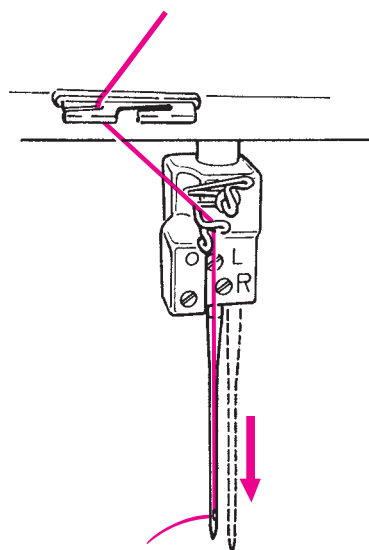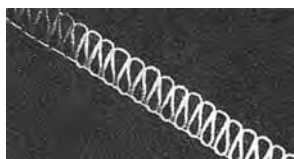（1）上弯针线（蓝色）
（2）下弯针线（红色）
（3）左机针线（黄色）
* 如果机器右机针线已经穿线完毕，剪下并除去多余的线。

2/3 thread converter

2／3线转换器

2-thread flatlock

2-thread wrapped overlock

How to use the 2/3 thread converter

* This attachment enables the machine to perform 2 thread overedging or decorative-stitching, using 2 needles to perform 3-thread super stretch stitching.

① Remove the upper looper thread, and insert the 2/3 thread converter into the top section (A) of the upper looper shaft and fit wire (B) into the hole in the upper looper.

Upper looper (C):
Push the wire behind looper and into the eye of the looper.

(D): If the wire is not sufficiently springy or it cannot be fitted in the hole in the upper looper smoothly, adjust the curved section of the wire.

② Pass the lower looper thread above the wire of the 2/3 thread converter and route it down under the presser foot (E).
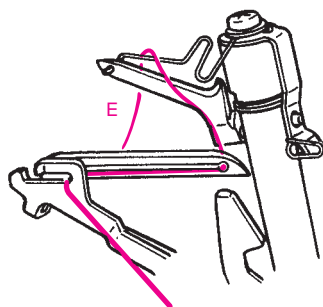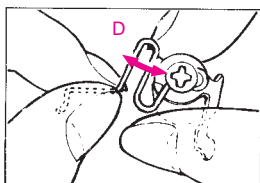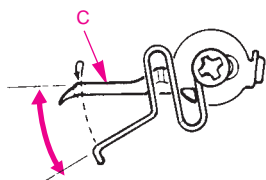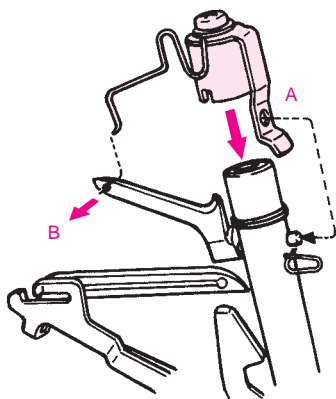
如何使用2／3线转换器

* 此配件可以使机器进行2线包缝或装饰包缝，用2机针来进行3线超级弹力伸缩缝。

①取下上弯针线，在上弯针轴的顶部（A）装入上弯针转换器，并将线钩（B）插入上弯针针孔里。

上弯针(C)：
将线钩插入弯针针孔。

(D)：如果线钩的弹性不够，或不能顺利的插进上弯针孔，请调整线钩的弯曲部分。

②将下弯针线穿过2／3线转换器的线钩的上方，然后放在压脚下面（E）。
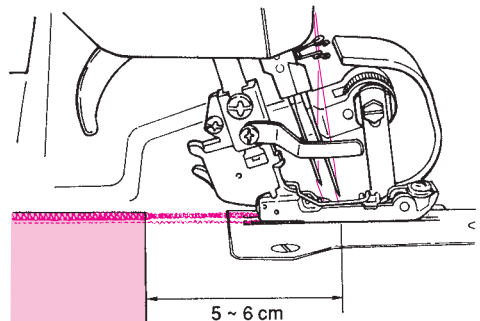
Trial sewing / 试缝

After threading, make a sample stitch.

Be sure to use a double layer of fabric in order to check whether the seam and thread tension for correctness.

Chainstitch sewing test:

1. Set the thread tension dials.
2. Lower the upper knife, depending on stitch choice.
3. Lower the presser foot.
4. When starting to sew chainstitch, place the fabric under the presser foot (chainstitch can only be sewn in fabric). Sew.
5. At the end of the seam, conftinue sewing to form a 5 to 6 cm long thread chain.
6. Holding the fabric with one hand, pull the thread chain over the thread cutter on the presser foot shank.

Overlock sewing test:

1. Set the thread tension dials.
2. Make sure that the upper knife is lowered, (in the cutting position).
3. Lower the presser foot.
4. Raise the tip of the presser foot with your thumb and place the fabric under the foot up to the knife. Let go of the foot and sew.
5. At the end of the seam, continue sewing to form a 5 to 6 cm long thread chain.
6. Holding the fabric with one hand, pull the thread chain over the thread cutter on the presser foot shank.
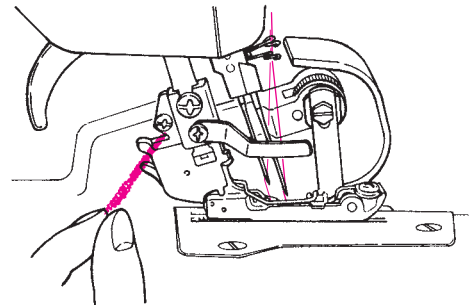
5 ~ 6 cm

穿线后，进行试缝。

请使用双层面料以检查缝口以及线的张力是否合适。

链缝试缝：

1. 设定线张力刻度。
2. 放下上刀，取决于选择的针迹。
3. 放下压脚。
4. 开始进行链缝时，将面料放在压脚下面（仅在面料上进行链行缝）。开始缝纫。
5. 在缝口的结束时，继续空缝5－6cm 。
6. 一手持面料，将线放在压脚切线器上切断线。

包缝试缝

1. 设定线张力刻度。
2. 确保放下上刀。（在切的位置）。
3. 放下压脚。
4. 抬起压脚前端，将面料放在压脚下面正对刀，用脚踩，开始缝纫。
5. 在缝口的结束时，继续空缝5－6cm。
6. 一手持面料，将线放在压脚切线器上切断线。

Thread tension dial

调节线张力

Adjusting the thread tension

Imperfect stitch formation can be corrected by adjusting the set value (1 to 9) on the thread tension dial.

	Adjusting thread tension dial	Standard of the thread tensioner dial
A	Upper looper thread tension	3 ~ 5
B	Lower looper thread tension	3 ~ 5
C	Right-hand needle thread tension	3 ~ 5
	Left-hand needle thread tension (for chainstitch and wide 3-thread overlock)	6 ~ 7
D	Chainstitch needle thread tension	2.5 ~ 4.5
	Left-hand needle thread tension	3 ~ 5

* When using filament thread or wooly nylon thread, adjust the thread tension accordingly.

D · A · C · B
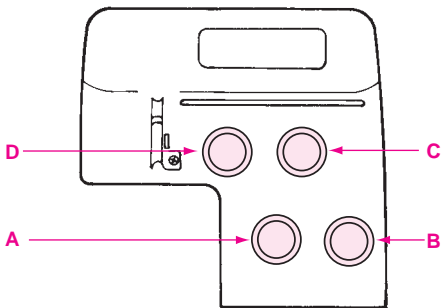
调节线张力

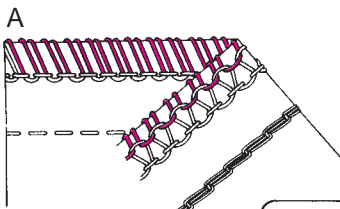通过调节线张力值（1-9），可以修正不美观的针迹。

	调整线张力调节旋钮	线张力调节旋钮刻度
A	上弯针旋钮	3～5
B	下弯针旋钮	3～5
C	右针旋钮	3～5
	左针旋钮（用于宽幅3-线包缝）	6～7
D	链缝机针旋钮	2.5～4.5
	左针旋钮	3～5

*当使用丝线或羊毛线时，请调整相应的线张力。

Increase
增加

Decrease
减小
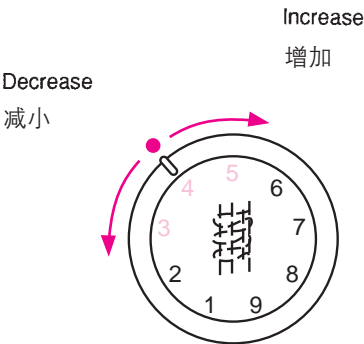
Adjusting the thread tension
调节线张力

A

Adjusting the thread tension

Turn the thread tension dial in the direction of the arrow, and make a trial sewing.

A – If the upper looper thread meet on the underside of the fabric:
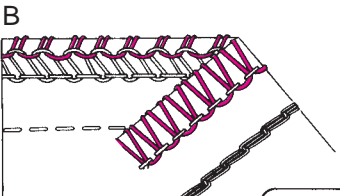B – If the lower looper thread meet on the upper side of the fabric:
C – If the right-hand needle thread forms loops on the underside of the fabric:
D – If the chainstitch needle thread forms loops on the underside of the fabric:
E – If the fabric puckers during sewing:
　　* Adjustment can be made by setting the lower knife adjusting knob to the smaller value on the scale.

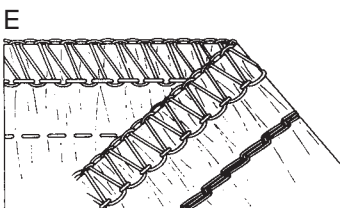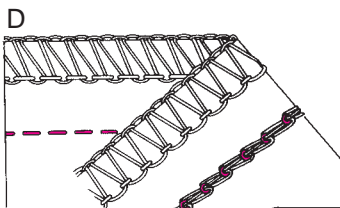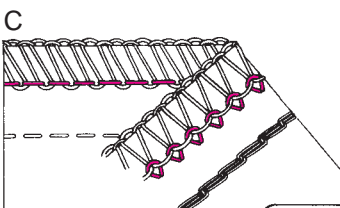**B**

调节线张力

按箭头所示调整线张力调节旋钮，然后试缝。

A－上弯针线环偏向面料反面。
B－下弯针线环偏向面料正面。
C－右针线针脚，在面料反面浮起。
D－链缝机针在面料反面权松垮。
E－面料被包在线环中起皱。
　　*调低下刀调节旋钮刻度，减少切刀宽度。

C

D

E

Sewing in tape
镶带缝

Sewing in tape

The standard presser foot is equipped with a tape guide. When sewing shoulders or side seams of stretchy fabrics as a knitted fabric, a tape works effectively to stabilize the seam.

1. Turn the handwheel toward you until the needles are fully raised.
2. Raise the presser foot, place the tape in the groove on the presser foot, and lower the presser foot.
3. Loosen the guide adjusting screw (A) to fit the tape guide (B) to the tape width, then tighten the screw.
4. Turn the handwheel manually to make two or three stitches in the tape.
5. Place the fabric to be sewn under the presser foot.
6. Sew, guiding the tape lightly.
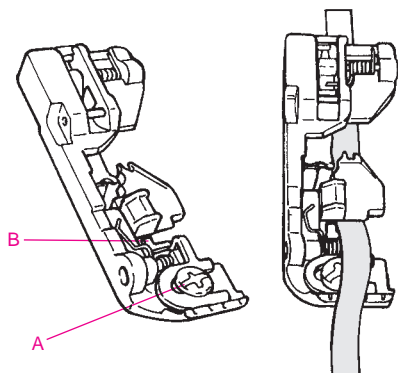
镶带缝

标准压脚上备有镶带导向装置，在缝制上衣肩部或延伸性织物边缘时用，可防止面料的伸展。
1. 正转飞轮，使机针转至最高点。
2. 抬起压脚，将镶带放入压脚槽，再放下压脚。
3. 拧松导向装置的调节螺钉（A），按镶带的宽度调节镶带导向装置（B）。
4. 用手正转飞轮，使线在带子上缝制2－3针。
5. 将面料放在压脚下面。
6. 缝制开始，带子会随面料一同行进。
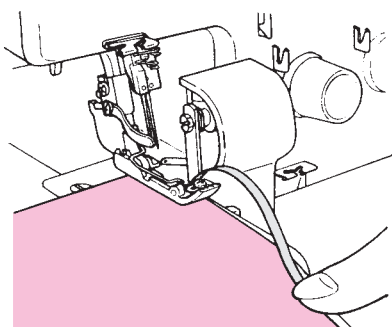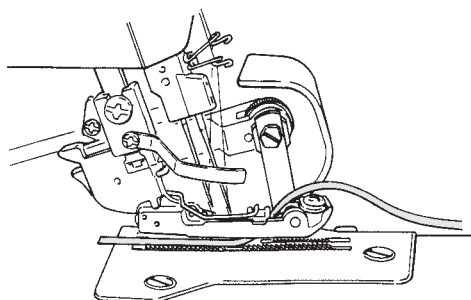
Roll hemming
卷缝

A

B

Roll hemmer
The roll hemmer is built-in to the sewing machine. The fabric edge is automatically rolled and oversewn. The result is a very fine and narrow edge finishing.

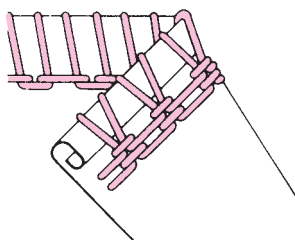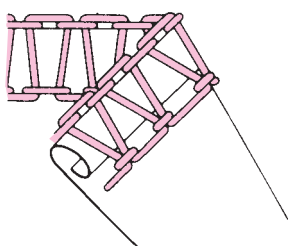Preparation for roll hemming
1. Remove the left-hand needle and thread the machine as for 3-thread overlocking.
2. Set the lower knife adjusting knob at "1 ~ 2".
3. Turn the overlocking width selection knob toward you to align with the red marking in front of the throat plate.
4. Set the stitch length adjusting knob at "1 ~ 1.5".
 * Adjust the thread tensions as desired. Tighten the lower looper tension.

(A): Rolled hem
Rolled hemming stitch sews the fabric edge with the upper looper thread.

(B): Narrow overlock stitch
Narrow overlock stitch is to sew normal overlock stitches of which cutting width is narrower than usual.

卷缝
卷边装置镶嵌在机器内部，面料边缘可被自动卷起并包缝，效果很佳，边缘窄且光滑。
1.取下左机针，使机器呈三线缝纫状。
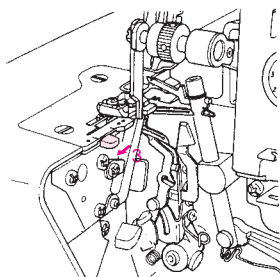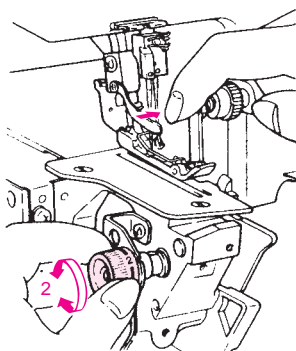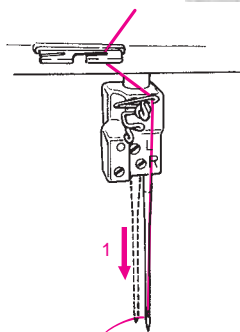2.将下刀调节旋钮调至"1-2"。
3.将包缝宽度选择扳手朝自己方向拉。
4.将针距调节旋钮调至"1-1.5"。
* 按需要调节线张力。增加下弯针张力。

（A）：卷边缝
卷边缝是使上弯针线全部覆盖在被卷面料下方。

（B）：窄边缝
是使卷边面料呈包缝状，但宽度窄于切刀宽度。

Standard thread tension list for roll hemming (rolled hem, narrow overlock stitch)
- ○ Thread tension slightly differs depending on the types of the fabric and thread.
- ○ Use the woolly nylon thread or thinner thread for roll hemming to attain the beautiful finish.
- ○ Use the thin spun thread thinner than #80.
- ○ Woolly nylon thread can be used only for the upper looper.

卷缝标准张力对照表（用于卷边缝和窄边缝）
- ○ 根据面料和线情况不同，线张力也稍有不同。
- ○ 用毛状尼龙或较细的线卷边，缝迹会显的更漂亮。
- ○ 用比80#还细的精纺线。
- ○ 毛状尼龙线只能用于弯针。

* Adjust the thread tensions as desired.

* 调节合适的线张力

• Thread tension dial value • 张力旋钮刻度	For rolled hem 卷边缝			For narrow overlock stitch 窄边缝		
	Right-hand needle 右机针	Upper looper 上弯针	Lower looper 下弯针	Right-hand needle 右机针	Upper looper 上弯针	Lower looper 下弯针
• Thread to be used • 线型号						
• Spun thread #80 • 精纺线80#	4 ~ 6	3 ~ 5	7 ~ 9	4 ~ 6	5 ~ 7	4 ~ 6
• Filament thread #80 • 棉线80#	3 ~ 5	3 ~ 5	6 ~ 8	3 ~ 5	3 ~ 5	3 ~ 5
• Woolly nylon thread • 毛状尼龙线		3 ~ 5			3 ~ 5	

Differential feed
差动送料
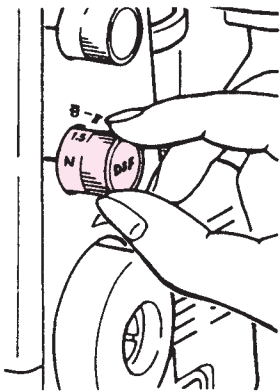
Differential feed

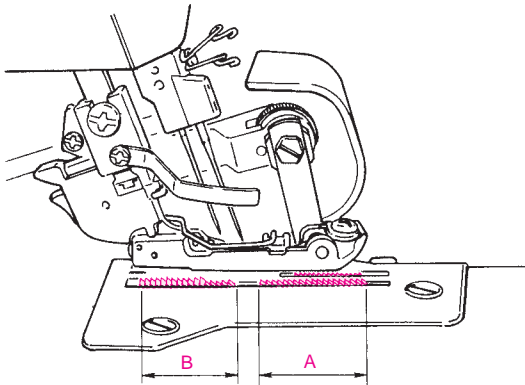Gathering and stretching of the fabric can be adjusted by adjusting the differential feed adjusting knob (differentiate the feeding amount of front feed dog (A) or rear feed dog (B).) After adjusted, be sure to sew on trial.

差动送料

布料需打裥或伸展时，可以通过差动送料调节旋钮来调节（调节送布牙前牙A和送布牙后牙B的送料比）。调节后须试缝。

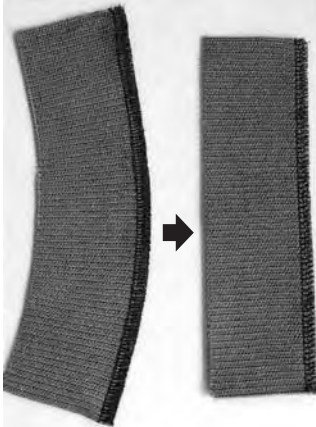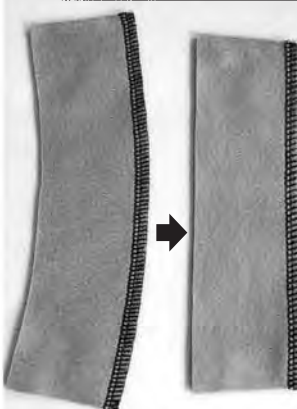|	Sewn with waves 缝口出现波浪			Sewn with puckerings 缝口起皱
Fabric / 面料	• Wool knit, thick hand-knitted garments, and other stretchy fabrics · 毛织物、手编织物、其他延伸性面料、针织面料	• Thin knitted fabric, knitted garments, and jersey · 薄型编织物、手编织物、平针织物	• Woven fabrics · 针织面料	• Georgette, linen, satin, poplin · 乔其纱、亚麻布、缎子、毛革

Set value of the differential feed adjusting knob/Ajuste el valor
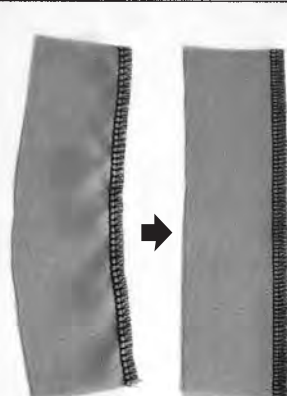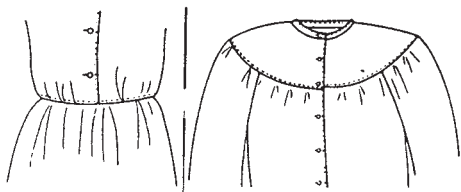
可通过调节差动送料调节旋钮实现

N → 1.5 ~ 2	N → 1.5	N	N → 0.7

Gathering / 打褶
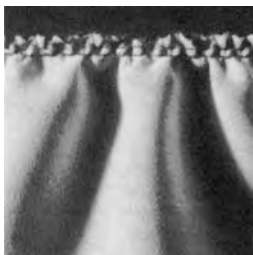
Gathering

1. A single layer of light-weight fabric can be gathered.
2. Set the stitch length adjusting knob at max. "4".
3. Set the differential feed adjusting knob at "1.5 ~ 2".

For examples: Sleeve heads, lower edges, yokes, lace edging or frills

* When sewing without differential feed, set the differential feed adjusting knob at "N".

打褶

1. 单层薄型面料可以进行打褶。
2. 将送料调节旋钮调至最大位置 "4"。
3. 将差动送料调节旋钮调至 "1.5—2"。

* 当无须差动送料，可将差动送料旋钮调至"N"。

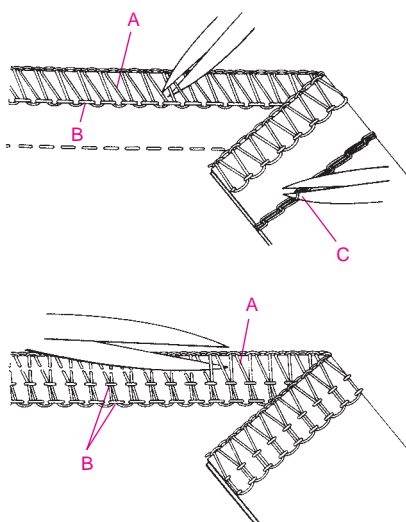4-thread gathering

4线打褶

3-thread gathering

3线打褶

Unpicking seams

Unpicking the seams of the 4 or 3-thread overlock
Cut the thread at (A), (C) with scissors, and pull needle thread (B).
The stitches will come undone.

缝口的拆法

拆开4线或3线包缝缝口
在（A）点处用剪刀（C）剪断线环，拉出机针线（B）。
针脚就会被拆开。

Thread breakage during sewing
缝纫中断线

Thread breakage during sewing

1. Turn the workpiece at a right angle direction and stop sewing immediately. Then remove the workpiece.
2. Rethread
 * If the lower looper thread is broken, cut the both needle threads off at the needle. Then remove the threads. Thread the lower looper and then the needles.
 * If the upper looper thread is broken, remove the looper to lowest position. Then thread the looper thread.
   Bring the thread through under the presser foot and pull about 10 cm of the thread out behind the presser foot.
3. Raise the presser foot, and place the workpiece under the presser foot. Sew about 2 to 3 cm over the seam which has already been sewn before the thread breakage.
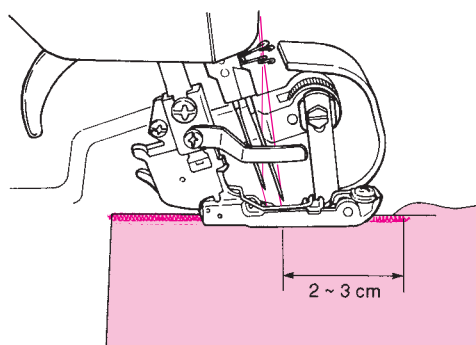
2 ~ 3 cm

缝纫中断线

1.马上停止缝纫，取出面料。
2.重新穿线。
 * 如果下弯针断线，则剪断左、右机针线，并抽掉余线，待下弯针线穿好后，再穿左、右机针线。
 * 如果上弯针断线，则剪断左右机针线，并抽掉余线，将上弯针转至最下位置，然后给上弯针穿线。
   将线放在压脚下并从后拉出大约 10 cm。
3.抬起压脚，将面料放在压脚下。在断线前面2-3 cm开始重新缝纫。

Securing seams
缝口的收拢

Securing seams

1. Sew about 3 to 4 cm of the thread chain at the beginning of seams.
2. Sew 2 to 3 stitches on the fabric.
3. Lower the needle and raise the presser foot.
4. Stretch the thread chain and lay it between the presser foot and the fabric from the left.
5. Lower the presser foot and sew over the thread chain.
   If you do not sew over the thread chain, be sure to leave enough thread chain at the beginning and end of a seam so that it can be knotted or pulled through the stitches with a darning needle.
 * When seams cross over one another, the thread chain is automatically closed.

缝口的收拢

1. 先缝3—4 cm 的空环。
2. 在面料上缝制2—3针。
3. 放下机针，抬起压脚。
4. 拉长空环，并从左面把它放入压脚与面料间。
5. 放下压脚，将空环与面料一起缝纫。
   如果不在空环上缝，就必须在缝口的始末处留以足够的空环，以便打结或用织补针穿入缝口。
   * 当缝口互相交叉时，缝迹便自动闭合。
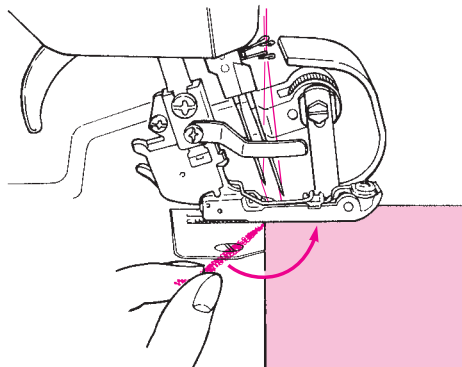
Replacing the upper knife

The upper knife is made of special extra-hard steel and does not need to be replaced.
Replace the upper knife only when the knife blade tip is damaged.
For a replacement, contact your local dealer.

Replacing the lower knife

⚠ Be sure to turn the power switch OFF.
1. Turn the handwheel toward you until the needles are fully raised.
2. Release the upper knife.
3. Loosen the setscrews on the lower knife retaining plate with the large screwdriver. Then remove the lower knife.
4. Fit the replacement knife (spare lower knife) into the groove and attach the lower knife to the knife vertical motion adjuster.
   (The tip of the lower knife blade aligns with the upper surface of the throat plate.)
5. Tighten the setscrews on the lower knife retaining plate securely.
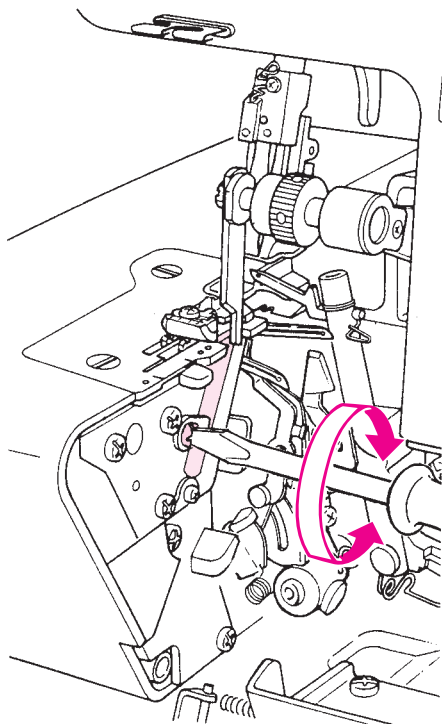
更换上刀

上刀是由特殊的超硬钢制成，无须更换。
仅在刀刃损坏时更换上刀。
更换时，联系当地经销商。
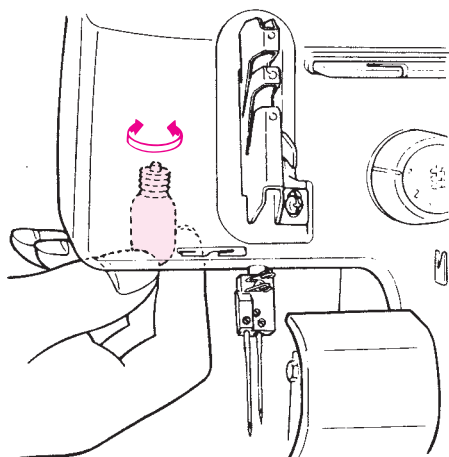
更换下刀

⚠ 注意切断电源。
1.正转飞轮使机针处于最高点。
2.翻起上刀。
3.用大螺丝刀拧开下刀固定的螺丝，取下下刀。
4.将置换的刀（配置的下刀）插入下刀槽里，并将下刀后端紧靠在下刀高度调节台上。（下刀刃端与针板的上表面平齐）。
5.拧紧下刀固定板螺丝。

Maintenance / 保养

Replacing the bulb

Be sure to turn the power switch OFF.
Unscrew the bulb and replace it with a new one. The power consumption of the bulb is 10W (230V, 240V), The bulbs are available from your local dealer.

更换灯泡

注意切断电源。
旋下灯泡，换上新的。灯泡规格为10W（230V、240V）。可从当地经销商处购买。

Cleaning and lubrication

During sewing, dust and fluff collects in and on the machine. Remove the dust and fluff regularly. Your sewing machine requires a little lubrication as the main components of the sewing machine are made from special materials. Apply a few drops of oil to the part illustrated in the figure.
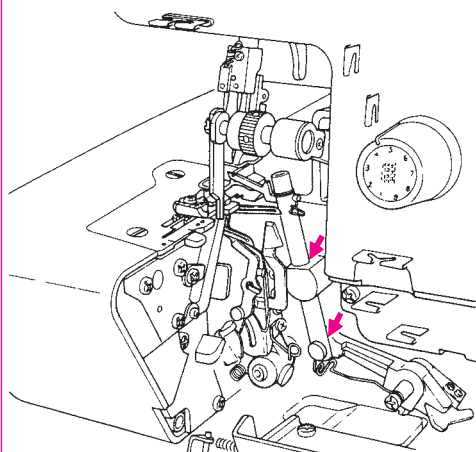
清洁注油

缝纫过程中，布屑和绒毛会散落在机器表面和内部，所以必须经常清理。由于机器的一些重要零件制作工艺特殊，故需要注油润滑，如图所示部位注上数滴油即可。

Before you call for help: Troubles and corrective measures

The following problems should not be regarded as the machine trouble. Check the following table before you call for help from us.

Trouble	Cause (reason)	Corrective measures	Page for reference
Fabric does not feed.	● Presser foot pressure is too low.	Increase the presser foot pressure by turning the presser foot pressure adjusting screw to the right.	10
Needles break	● Needles are bent, or the needle point is blunt. ● Needles are incorrectly inserted. ● The fabric cloth is excessively stretched.	Replace the needles. Insert the needle correctly. Hold the edge of the material cloth lightly with your hand when sewing.	11 11 –
Thread breaks	● The machine is incorrectly threaded. ● Thread tension is too high. ● Needles are incorrectly inserted.	Rethread the machine correctly. Adjust the thread tension properly. Insert the needles correctly.	14~26 29, 30 11
Stitch skips	● Needles are bent or needle point is blunt. ● Needles are incorrectly inserted. ● The machine is incorrectly threaded.	Replace the needles. Insert the needles correctly. Rethread the machine correctly.	11 11 14~26
Poor stitches are formed	● Thread tension is not proper.	Adjust the thread tension properly.	29, 30
Seams flute or wave, especially when sewing knits	● Presser foot pressure is too high. ● Differential feed is set incorrectly.	Reduce presser foot pressure. Adjust differential feed to N–2.	10 34
Seams pucker	● Thread tension is too high. ● Differential feed is set incorrectly.	Set the thread tension adjusting dial to the smaller value. Adjust differential feed to 0.7–N.	29, 30 34
Motor trouble	● The motor makes noise. ● The motor will not rotate. ● Unusually large sparks are emitted.	Dealer should the carbon brush.	–

When the trouble is not corrected by the above measures, contact your local dealer.

故障排除指南

下列故障并非机器故障，请线查阅报表，在向我们提出维修。

故障	原因	处理方法	参考页次
面料不行进	●压脚压力太低	将调压螺钉顺时针旋，以增加压脚压力	10
断针	●机针弯曲或针尖磨损 ●机针装错 ●面料过度拉长	换针 正确装针 缝制时用手轻拉面料	11 11 —
断线	●穿线错误 ●线张力过大 ●机针装错	重新正确穿线 适当调节线张力 正确装针	14—26 29、30 11
跳针	●机针弯曲或针尖磨损 ●机针装错 ●穿线错误	换针 正确装针 重新正确穿线	11 11 14—26
线迹成形不好	●线张力不当	调节合适的线张力	29、30
缝口凹陷波状，尤以针织物常见	●压脚压力太大 ●差动送料调节旋钮位置错误	减小压脚压力 将差动旋钮调至N—2	10 34
缝口起皱	●线张力过高 ●差动旋钮位置不对	减小线张力 将差动旋钮调整为0.7—N	29、30 34
马达故障	●马达噪音 ●马达不转 ●出现罕见火花	更换电机碳刷	—

如故障仍不能排除，请联系当地经销商。

Specifications
规格

Specifications

Item	Specifications
Number of threads	5 threads, 4 threads, 3 threads, 2 threads
Needles	130/705H
Overlocking width	Left-hand needle : 6 mm Right-hand needle : 4 mm (for roll hemming : 2 mm) Chainstitch needle : 10 mm
Stitch length (feeding amount)	1 to 4 mm (standard stitch length : 2.5 mm)
Differential feed	No waving or fluting in knits N-2. No puckering 0.7-N
Presser foot lift	5 mm
Sewing speed	Max. 1,500 s.p.m.
Dimensions	315 (W) × 345 (D) × 295 (H) mm
Weight	7.4 kg
Foot control	230V .....Model nr. YC483N

规格

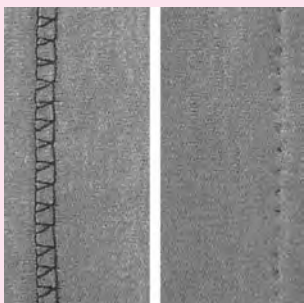| 项目	规格
用线数	5线、4线、3线、2线
机针	130/705H
包缝宽度	左机针：6 mm 右机针：4 mm （卷缝：2 mm） 链缝机针：10 mm
针距（送料量）	1—4 mm （标准针距：2.5 mm）
差动送料	针织品无波纹或延伸：N—2 无起皱：0.7—N
压脚升降高度	5 mm
缝速	最大1500针/分
外形尺寸	315 (W) *345 (D) *295 (H) mm
重量	7.4 kg
脚踏控速器	230V...Model nr. YC483N

Optional accessories
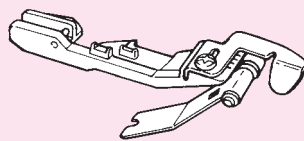# 另购附件

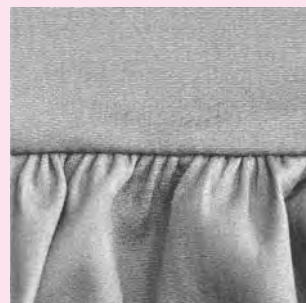- Blind stitch presser foot
- 暗缝压脚
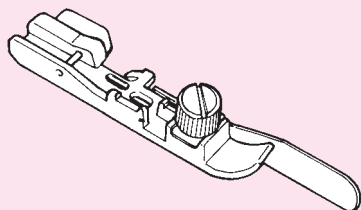
A9810 634 0A0
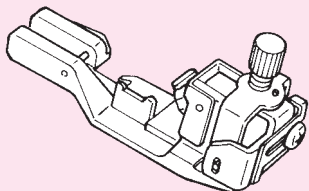
- Gathering presser foot
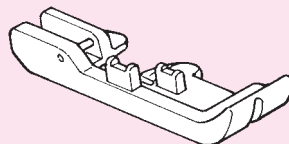- 聚裥压脚

A9860 634 0A0

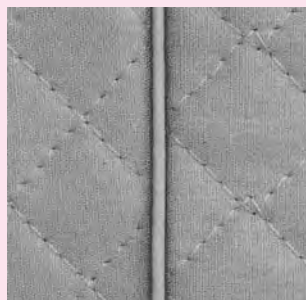- Elasticator
- 弹簧压脚

A9815 634 0A0
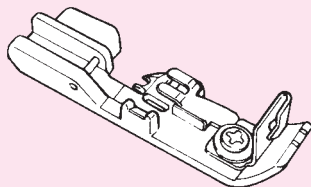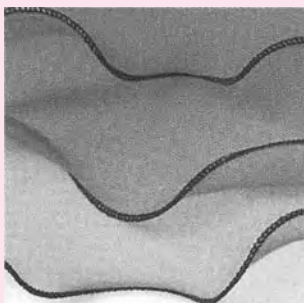
- Piping presser foot
- 滚带压脚

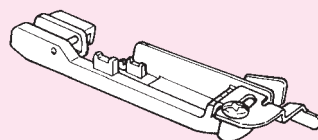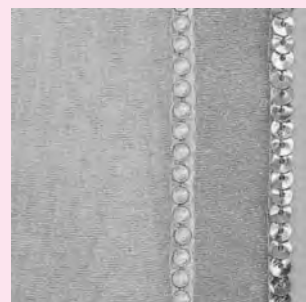A9865 634 0A0

- Cording presser foot
- 花边压脚

A9820 634 0A0

- Beading presser foot
- 珍珠压脚

A9870 634 0A0

Contact your local dealer.
如需上述附件，请与当地购买店联系。

JUKI®

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